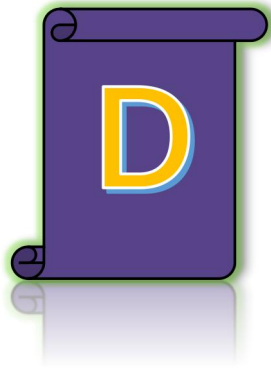


Drilling Insert

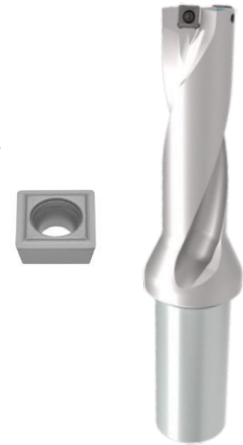


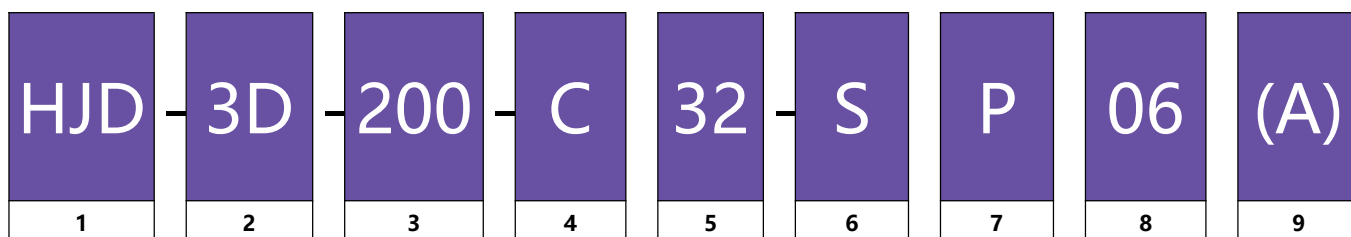
Drilling Tools

Identification rules for drilling tools

Specification for drilling tools

Recommended cutting data





1.Tool Type	
HJD	Hongjiang Drill

2.Aspect Ratio
2D/3D/4D/5D

3.Dia of Drill
Range: 20~59mm

4.Shank Type
C: Flange-Flat

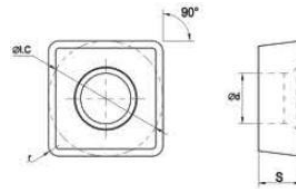
5.Shank Size
Φ32mm

6.Insert Shape	
W	
S	

7.Insert Bank Angle	
C	7°
P	11°

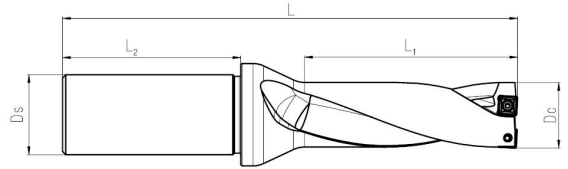
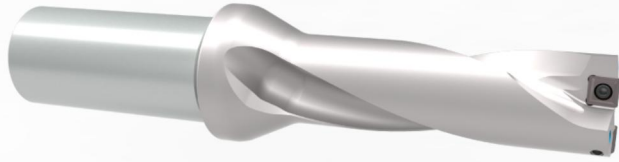
8.Cutting Edge Length		
symbol	Flute Length	
	W	S
03	3.8	
04	4.3	
05	5.4	5.0
06	6.5	6.0
07		7.94
08	8.7	
09		9.8
11		11.5

9.Inner Coolant Type	
A	Standard
B	Customize

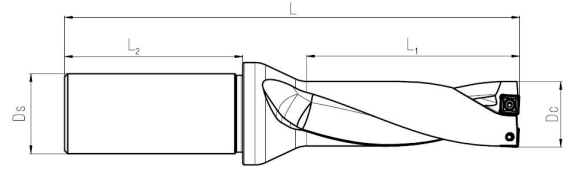
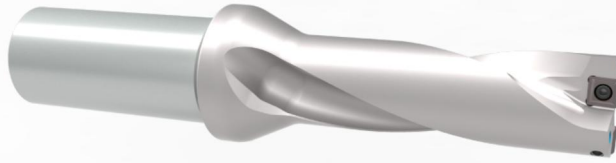


Insert Type Specification/Item	Dia. of Drill	Dimensions (mm)				Grade
		ϕC	s	d	r	U8120
SPMG050204	13~16	5	2.38	2.5	0.4	●
SPMG060204	16~22	6	2.38	2.61	0.4	●
SPMG07T308	23~29	7.94	3.97	2.85	0.8	●
SPMG090408	30~36	9.8	4.3	4.05	0.8	●
SPMG110408	37~43	11.5	4.8	4.45	0.8	●
SPMG140512	44~50	14.3	5.2	5.75	1.2	●

2D

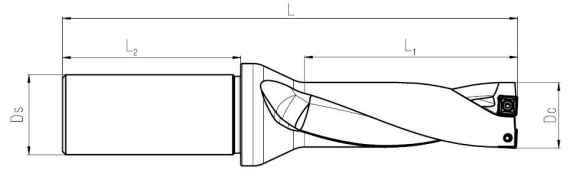
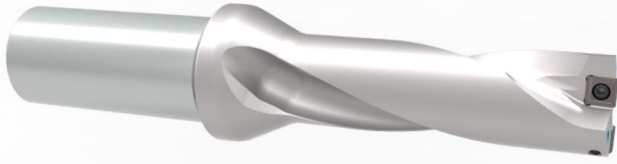


Specification/Item	Stock	Dimensions (mm)					Insert
		ϕD	ϕDS	L	L1	L2	
HJD-2D-130-C20-SP05	○	13	20	97	26	50	SPMG050204
HJD-2D-135-C20-SP05	○	13.5		98	27	50	
HJD-2D-140-C20-SP05	○	14		99	28	50	
HJD-2D-145-C20-SP05	○	14.5		100	29	50	
HJD-2D-150-C20-SP05	○	15		101	30	50	
HJD-2D-155-C25-SP05	○	15.5		108	31	56	
HJD-2D-160-C25-SP05	○	16	25	109	32	56	SPMG060204
HJD-2D-165-C25-SP06	○	16.5		110	33	56	
HJD-2D-170-C25-SP06	○	17		111	34	56	
HJD-2D-175-C25-SP06	○	17.5		112	35	56	
HJD-2D-180-C25-SP06	○	18		113	36	56	
HJD-2D-185-C25-SP06	○	18.5		114	37	56	
HJD-2D-190-C25-SP06	○	19		115	38	56	
HJD-2D-195-C25-SP06	○	19.5		116	39	56	
HJD-2D-200-C25-SP06	○	20		117	40	56	
HJD-2D-205-C25-SP06	○	20.5		118	41	56	
HJD-2D-210-C25-SP06	○	21		119	42	56	
HJD-2D-215-C25-SP06	○	21.5		120	43	56	
HJD-2D-220-C25-SP06	○	22	32	121	44	56	SPMG07T308
HJD-2D-225-C25-SP06	○	22.5		122	45	56	
HJD-2D-230-C32-SP07	○	23		132	46	60	
HJD-2D-235-C32-SP07	○	23.5		133	47	60	
HJD-2D-240-C32-SP07	○	24		134	48	60	
HJD-2D-245-C32-SP07	○	24.5		135	49	60	
HJD-2D-250-C32-SP07	○	25		136	50	60	
HJD-2D-255-C32-SP07	○	25.5		137	51	60	
HJD-2D-260-C32-SP07	○	26		138	52	60	
HJD-2D-265-C32-SP07	○	26.5		139	53	60	
HJD-2D-270-C32-SP07	○	27		140	54	60	
HJD-2D-275-C32-SP07	○	27.5	141	55	60		
HJD-2D-280-C32-SP07	○	28	142	56	60		
HJD-2D-285-C32-SP07	○	28.5	143	57	60		



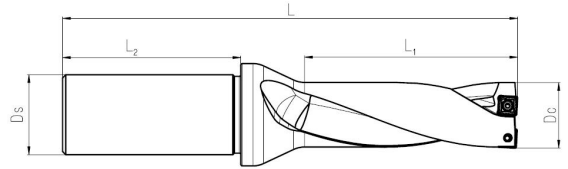
Specification/Item	Stock	Dimensions (mm)					Insert
		φD	φDS	L	L1	L2	
HJD-2D-290-C32-SP09	○	29	32	144	58	60	SPMG090408
HJD-2D-295-C32-SP09	○	29.5		145	59	60	
HJD-2D-300-C32-SP09	○	30		146	60	60	
HJD-2D-305-C32-SP09	○	30.5		147	61	60	
HJD-2D-310-C40-SP09	○	31	40	161	62	70	
HJD-2D-315-C40-SP09	○	31.5		162	63	70	
HJD-2D-320-C40-SP09	○	32		163	64	70	
HJD-2D-325-C40-SP09	○	32.5		164	65	70	
HJD-2D-330-C40-SP09	○	33		165	66	70	
HJD-2D-335-C40-SP09	○	33.5		166	67	70	
HJD-2D-340-C40-SP09	○	34		167	68	70	
HJD-2D-345-C40-SP09	○	34.5		168	69	70	
HJD-2D-350-C40-SP11	○	35		169	70	70	
HJD-2D-355-C40-SP11	○	35.5		170	71	70	
HJD-2D-360-C40-SP11	○	36		171	72	70	
HJD-2D-365-C40-SP11	○	36.5		172	73	70	
HJD-2D-370-C40-SP11	○	37		173	74	70	
HJD-2D-375-C40-SP11	○	37.5		174	75	70	
HJD-2D-380-C40-SP11	○	38		175	76	70	
HJD-2D-385-C40-SP11	○	38.5		176	77	70	
HJD-2D-390-C40-SP11	○	39	177	78	70		
HJD-2D-395-C40-SP11	○	39.5	178	79	70		
HJD-2D-400-C40-SP11	○	40	179	80	70		
HJD-2D-410-C40-SP11	○	41	181	82	70		
HJD-2D-420-C40-SP11	○	42	183	84	70		
HJD-2D-430-C40-SP11	○	43	185	86	70		
HJD-2D-440-C40-SP14	○	44	187	88	70	SPMG140512	
HJD-2D-450-C40-SP14	○	45	189	90	70		
HJD-2D-460-C40-SP14	○	46	191	92	70		
HJD-2D-470-C40-SP14	○	47	193	94	70		
HJD-2D-480-C40-SP14	○	48	195	96	70		
HJD-2D-490-C40-SP14	○	49	197	98	70		

2D



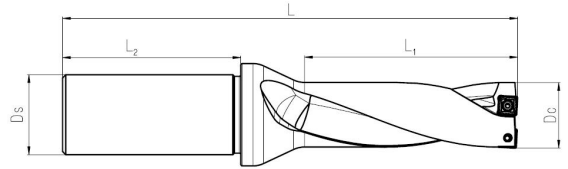
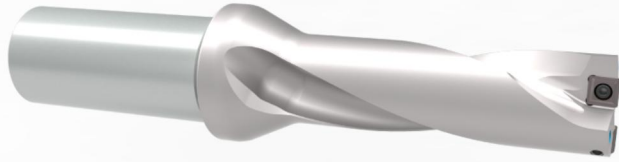
Specification/Item	Stock	Dimensions (mm)					Insert
		ϕD	ϕDS	L	L1	L2	
HJD-2D-500-C40-SP14	○	50	40	199	100	70	SPMG140512
HJD-2D-510-C40-SP14	○	51		201	102	70	
HJD-2D-520-C40-SP14	○	52		203	104	70	
HJD-2D-530-C40-SP14	○	53		205	106	70	
HJD-2D-540-C40-SP14	○	54		207	108	70	
HJD-2D-550-C40-SP14	○	55		209	110	70	

3D



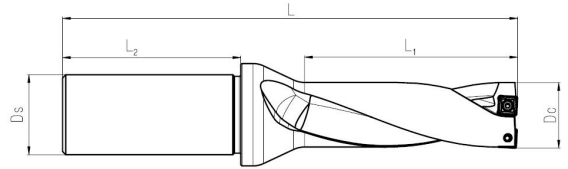
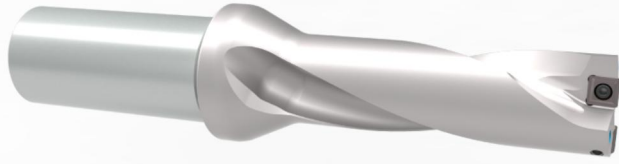
Specification/Item	Stock	Dimensions (mm)					Insert
		ϕD	ϕD_S	L	L1	L2	
HJD-3D-130-C20-SP05	○	13	20	110	39	50	SPMG050204
HJD-3D-135-C20-SP05	○	13.5		111.5	41	50	
HJD-3D-140-C20-SP05	○	14		113	42	50	
HJD-3D-145-C20-SP05	○	14.5		114.5	44	50	
HJD-3D-150-C20-SP05	●	15		116	45	50	
HJD-3D-155-C25-SP05	●	15.5	25	123.5	47	56	SPMG060204
HJD-3D-160-C25-SP05	●	16		125	48	56	
HJD-3D-165-C25-SP06	●	16.5		126.5	50	56	
HJD-3D-170-C25-SP06	●	17		128	51	56	
HJD-3D-175-C25-SP06	●	17.5		129.5	53	56	
HJD-3D-180-C25-SP06	●	18		131	54	56	
HJD-3D-185-C25-SP06	●	18.5		132.5	56	56	
HJD-3D-190-C25-SP06	●	19		134	57	56	
HJD-3D-195-C25-SP06	●	19.5		135.5	59	56	
HJD-3D-200-C25-SP06	●	20		137	60	56	
HJD-3D-205-C25-SP06	●	20.5		138.5	62	56	
HJD-3D-210-C25-SP06	●	21		140	63	56	
HJD-3D-215-C25-SP06	●	21.5		141.5	65	56	
HJD-3D-220-C25-SP06	●	22		143	66	56	
HJD-3D-225-C25-SP06	●	22.5		144.5	68	56	
HJD-3D-230-C32-SP07	●	23	32	155	69	60	SPMG07T308
HJD-3D-235-C32-SP07	●	23.5		156.5	71	60	
HJD-3D-240-C32-SP07	●	24		158	72	60	
HJD-3D-245-C32-SP07	●	24.5		159.5	74	60	
HJD-3D-250-C32-SP07	●	25		161	75	60	
HJD-3D-255-C32-SP07	○	25.5		162.5	77	60	
HJD-3D-260-C32-SP07	○	26		164	78	60	
HJD-3D-265-C32-SP07	○	26.5		165.5	80	60	
HJD-3D-270-C32-SP07	○	27		167	81	60	
HJD-3D-275-C32-SP07	○	27.5		168.5	83	60	
HJD-3D-280-C32-SP07	○	28		170	84	60	
HJD-3D-285-C32-SP07	○	28.5		171.5	86	60	

3D



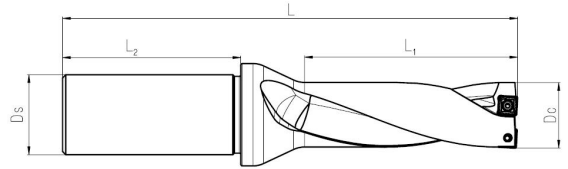
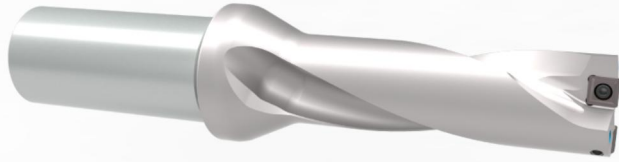
Specification/Item	Stock	Dimensions (mm)					Insert
		ϕD	ϕD_S	L	L1	L2	
HJD-3D-290-C32-SP09	○	29	32	173	87	60	SPMG090408
HJD-3D-295-C32-SP09	○	29.5		174.5	89	60	
HJD-3D-300-C32-SP09	○	30		176	90	60	
HJD-3D-305-C32-SP09	○	30.5		177.5	92	60	
HJD-3D-310-C40-SP09	○	31	40	192	93	70	
HJD-3D-315-C40-SP09	○	31.5		193.5	95	70	
HJD-3D-320-C40-SP09	○	32		195	96	70	
HJD-3D-325-C40-SP09	○	32.5		196.5	98	70	
HJD-3D-330-C40-SP09	○	33		198	99	70	
HJD-3D-335-C40-SP09	○	33.5		199.5	101	70	
HJD-3D-340-C40-SP09	○	34		201	102	70	
HJD-3D-345-C40-SP09	○	34.5		202.5	104	70	
HJD-3D-350-C40-SP11	○	35		204	105	70	SPMG110408
HJD-3D-355-C40-SP11	○	35.5		205.5	107	70	
HJD-3D-360-C40-SP11	○	36		207	108	70	
HJD-3D-365-C40-SP11	○	36.5		208.5	110	70	
HJD-3D-370-C40-SP11	○	37		210	111	70	
HJD-3D-375-C40-SP11	○	37.5		211.5	113	70	
HJD-3D-380-C40-SP11	○	38		213	114	70	
HJD-3D-385-C40-SP11	○	38.5		214.5	116	70	
HJD-3D-390-C40-SP11	○	39	216	117	70		
HJD-3D-395-C40-SP11	○	39.5	217.5	119	70		
HJD-3D-400-C40-SP11	○	40	219	120	70		
HJD-3D-410-C40-SP11	○	41	222	123	70		
HJD-3D-420-C40-SP11	○	42	225	126	70	SPMG140512	
HJD-3D-430-C40-SP11	○	43	228	129	70		
HJD-3D-440-C40-SP14	○	44	231	132	70		
HJD-3D-450-C40-SP14	○	45	234	135	70		
HJD-3D-460-C40-SP14	○	46	237	138	70		
HJD-3D-470-C40-SP14	○	47	240	141	70		
HJD-3D-480-C40-SP14	○	48	243	144	70		
HJD-3D-490-C40-SP14	○	49	246	147	70		

3D



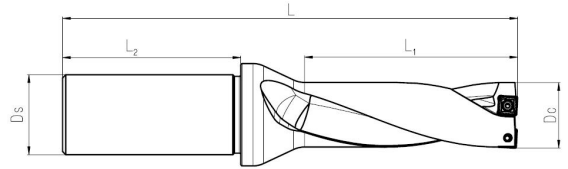
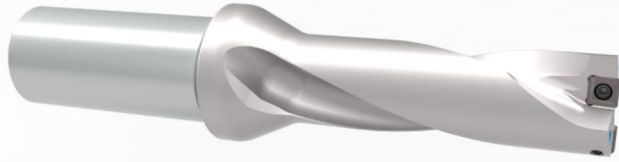
Specification/Item	Stock	Dimensions (mm)					Insert
		ϕD	ϕDS	L	L1	L2	
HJD-3D-500-C40-SP14	○	50	40	249	150	70	SPMG140512
HJD-3D-510-C40-SP14	○	51		252	153	70	
HJD-3D-520-C40-SP14	○	52		255	156	70	
HJD-3D-530-C40-SP14	○	53		258	159	70	
HJD-3D-540-C40-SP14	○	54		261	162	70	
HJD-3D-550-C40-SP14	○	55		264	165	70	

4D



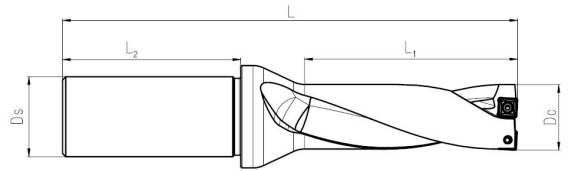
Specification/Item	Stock	Dimensions (mm)					Insert
		ϕD	ϕD_S	L	L1	L2	
HJD-4D-130-C20-SP05	○	13	20	123	52	50	SPMG050204
HJD-4D-135-C20-SP05	○	13.5		125	54	50	
HJD-4D-140-C20-SP05	○	14		127	56	50	
HJD-4D-145-C20-SP05	○	14.5		129	58	50	
HJD-4D-150-C20-SP05	○	15		131	60	50	
HJD-4D-155-C25-SP05	○	15.5		139	62	56	
HJD-4D-160-C25-SP05	○	16	25	141	64	56	SPMG060204
HJD-4D-165-C25-SP06	○	16.5		143	66	56	
HJD-4D-170-C25-SP06	○	17		145	68	56	
HJD-4D-175-C25-SP06	○	17.5		147	70	56	
HJD-4D-180-C25-SP06	○	18		149	72	56	
HJD-4D-185-C25-SP06	○	18.5		151	74	56	
HJD-4D-190-C25-SP06	○	19		153	76	56	
HJD-4D-195-C25-SP06	○	19.5		155	78	56	
HJD-4D-200-C25-SP06	○	20		157	80	56	
HJD-4D-205-C25-SP06	○	20.5		159	82	56	
HJD-4D-210-C25-SP06	○	21		161	84	56	
HJD-4D-215-C25-SP06	○	21.5		163	86	56	
HJD-4D-220-C25-SP06	○	22	32	165	88	56	SPMG07T308
HJD-4D-225-C25-SP06	○	22.5		167	90	56	
HJD-4D-230-C32-SP07	○	23		178	92	60	
HJD-4D-235-C32-SP07	○	23.5		180	94	60	
HJD-4D-240-C32-SP07	○	24		182	96	60	
HJD-4D-245-C32-SP07	○	24.5		184	98	60	
HJD-4D-250-C32-SP07	○	25		186	100	60	
HJD-4D-255-C32-SP07	○	25.5		188	102	60	
HJD-4D-260-C32-SP07	○	26		190	104	60	
HJD-4D-265-C32-SP07	○	26.5		192	106	60	
HJD-4D-270-C32-SP07	○	27		194	108	60	
HJD-4D-275-C32-SP07	○	27.5		196	110	60	
HJD-4D-280-C32-SP07	○	28	198	112	60		
HJD-4D-285-C32-SP07	○	28.5	200	114	60		

4D



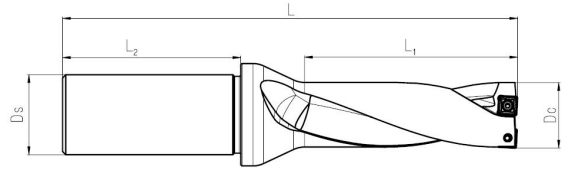
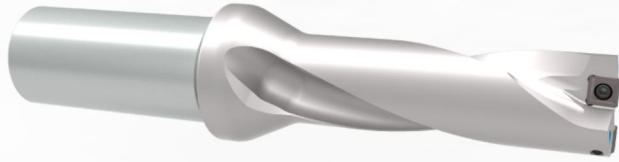
Specification/Item	Stock	Dimensions (mm)					Insert
		φD	φDS	L	L1	L2	
HJD-4D-290-C32-SP09	○	29	32	202	116	60	SPMG090408
HJD-4D-295-C32-SP09	○	29.5		204	118	60	
HJD-4D-300-C32-SP09	○	30		206	120	60	
HJD-4D-305-C32-SP09	○	30.5		208	122	60	
HJD-4D-310-C40-SP09	○	31	40	223	124	70	
HJD-4D-315-C40-SP09	○	31.5		225	126	70	
HJD-4D-320-C40-SP09	○	32		227	128	70	
HJD-4D-325-C40-SP09	○	32.5		229	130	70	
HJD-4D-330-C40-SP09	○	33		231	132	70	
HJD-4D-335-C40-SP09	○	33.5		233	134	70	
HJD-4D-340-C40-SP09	○	34		235	136	70	
HJD-4D-345-C40-SP09	○	34.5		237	138	70	
HJD-4D-350-C40-SP11	○	35		239	140	70	
HJD-4D-355-C40-SP11	○	35.5		241	142	70	
HJD-4D-360-C40-SP11	○	36		243	144	70	
HJD-4D-365-C40-SP11	○	36.5		245	146	70	
HJD-4D-370-C40-SP11	○	37		247	148	70	
HJD-4D-375-C40-SP11	○	37.5		249	150	70	
HJD-4D-380-C40-SP11	○	38		251	152	70	
HJD-4D-385-C40-SP11	○	38.5		253	154	70	
HJD-4D-390-C40-SP11	○	39		255	156	70	
HJD-4D-395-C40-SP11	○	39.5	257	158	70		
HJD-4D-400-C40-SP11	○	40	259	160	70		
HJD-4D-410-C40-SP11	○	41	263	164	70		
HJD-4D-420-C40-SP11	○	42	267	168	70		
HJD-4D-430-C40-SP11	○	43	271	172	70	SPMG140512	
HJD-4D-440-C40-SP14	○	44	275	176	70		
HJD-4D-450-C40-SP14	○	45	279	180	70		
HJD-4D-460-C40-SP14	○	46	283	184	70		
HJD-4D-470-C40-SP14	○	47	287	188	70		
HJD-4D-480-C40-SP14	○	48	291	192	70		
HJD-4D-490-C40-SP14	○	49	295	196	70		

4D



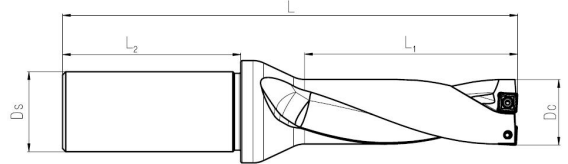
Specification/Item	Stock	Dimensions (mm)					Insert
		ϕD	ϕDS	L	L1	L2	
HJD-4D-500-C40-SP14	○	50	40	299	200	70	SPMG140512
HJD-4D-510-C40-SP14	○	51		303	204	70	
HJD-4D-520-C40-SP14	○	52		307	208	70	
HJD-4D-530-C40-SP14	○	53		311	212	70	
HJD-4D-540-C40-SP14	○	54		315	216	70	
HJD-4D-550-C40-SP14	○	55		319	220	70	

5D



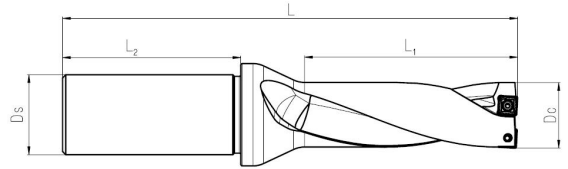
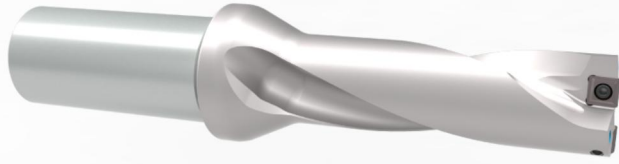
Specification/Item	Stock	Dimensions (mm)					Insert
		φD	φDS	L	L1	L2	
HJD-5D-130-C20-SP05	○	13	20	136	65	50	SPMG050204
HJD-5D-135-C20-SP05	○	13.5		138.5	68	50	
HJD-5D-140-C20-SP05	○	14		141	70	50	
HJD-5D-145-C20-SP05	○	14.5		143.5	73	50	
HJD-5D-150-C20-SP05	○	15		146	75	50	
HJD-5D-155-C25-SP05	○	15.5	25	154.5	78	56	SPMG060204
HJD-5D-160-C25-SP05	○	16		157	80	56	
HJD-5D-165-C25-SP06	○	16.5		159.5	83	56	
HJD-5D-170-C25-SP06	○	17		162	85	56	
HJD-5D-175-C25-SP06	○	17.5		164.5	88	56	
HJD-5D-180-C25-SP06	○	18		167	90	56	
HJD-5D-185-C25-SP06	○	18.5		169.5	93	56	
HJD-5D-190-C25-SP06	○	19		172	95	56	
HJD-5D-195-C25-SP06	○	19.5		174.5	98	56	
HJD-5D-200-C25-SP06	○	20		177	100	56	
HJD-5D-205-C25-SP06	○	20.5	179.5	103	56		
HJD-5D-210-C25-SP06	○	21	32	182	105	56	SPMG07T308
HJD-5D-215-C25-SP06	○	21.5		184.5	108	56	
HJD-5D-220-C25-SP06	○	22		187	110	56	
HJD-5D-225-C25-SP06	○	22.5		189.5	113	56	
HJD-5D-230-C32-SP07	○	23		201	115	60	
HJD-5D-235-C32-SP07	○	23.5		203.5	118	60	
HJD-5D-240-C32-SP07	○	24		206	120	60	
HJD-5D-245-C32-SP07	○	24.5		208.5	123	60	
HJD-5D-250-C32-SP07	○	25		211	125	60	
HJD-5D-255-C32-SP07	○	25.5		213.5	128	60	
HJD-5D-260-C32-SP07	○	26	216	130	60		
HJD-5D-265-C32-SP07	○	26.5	218.5	133	60		
HJD-5D-270-C32-SP07	○	27	221	135	60		
HJD-5D-275-C32-SP07	○	27.5	223.5	138	60		
HJD-5D-280-C32-SP07	○	28	226	140	60		
HJD-5D-285-C32-SP07	○	28.5	228.5	143	60		

5D



Specification/Item	Stock	Dimensions (mm)					Insert	
		ϕD	ϕD_S	L	L1	L2		
HJD-5D-290-C32-SP09	○	29	32	231	145	60	SPMG090408	
HJD-5D-295-C32-SP09	○	29.5		233.5	148	60		
HJD-5D-300-C32-SP09	○	30		236	150	60		
HJD-5D-305-C32-SP09	○	30.5		238.5	153	60		
HJD-5D-310-C40-SP09	○	31	40	254	155	70		
HJD-5D-315-C40-SP09	○	31.5		256.5	158	70		
HJD-5D-320-C40-SP09	○	32		259	160	70		
HJD-5D-325-C40-SP09	○	32.5		261.5	163	70		
HJD-5D-330-C40-SP09	○	33		264	165	70		
HJD-5D-335-C40-SP09	○	33.5		266.5	168	70		
HJD-5D-340-C40-SP09	○	34		269	170	70		
HJD-5D-345-C40-SP09	○	34.5		271.5	173	70		
HJD-5D-350-C40-SP11	○	35		274	175	70		SPMG110408
HJD-5D-355-C40-SP11	○	35.5		276.5	178	70		
HJD-5D-360-C40-SP11	○	36		279	180	70		
HJD-5D-365-C40-SP11	○	36.5		281.5	183	70		
HJD-5D-370-C40-SP11	○	37		284	185	70		
HJD-5D-375-C40-SP11	○	37.5		286.5	188	70		
HJD-5D-380-C40-SP11	○	38		289	190	70		
HJD-5D-385-C40-SP11	○	38.5		291.5	193	70		
HJD-5D-390-C40-SP11	○	39	294	195	70			
HJD-5D-395-C40-SP11	○	39.5	296.5	198	70			
HJD-5D-400-C40-SP11	○	40	299	200	70			
HJD-5D-410-C40-SP11	○	41	304	205	70			
HJD-5D-420-C40-SP11	○	42	309	210	70			
HJD-5D-430-C40-SP11	○	43	314	215	70			
HJD-5D-440-C40-SP14	○	44	319	220	70	SPMG140512		
HJD-5D-450-C40-SP14	○	45	324	225	70			
HJD-5D-460-C40-SP14	○	46	329	230	70			
HJD-5D-470-C40-SP14	○	47	334	235	70			
HJD-5D-480-C40-SP14	○	48	339	240	70			
HJD-5D-490-C40-SP14	○	49	344	245	70			

5D



Specification/Item	Stock	Dimensions (mm)					Insert
		ϕD	ϕDS	L	L1	L2	
HJD-5D-500-C40-SP14	○	50	40	349	250	70	SPMG140512
HJD-5D-510-C40-SP14	○	51		354	255	70	
HJD-5D-520-C40-SP14	○	52		359	260	70	
HJD-5D-530-C40-SP14	○	53		364	265	70	
HJD-5D-540-C40-SP14	○	54		369	270	70	
HJD-5D-550-C40-SP14	○	55		374	275	70	

Recommended Cutting Data

ISO	Workpiece	Hardness HB	Cutting Speed (m/min)	Feed (mm/rev)			
				Ø14.0 – 22.5	Ø23.0 – 27.0	Ø27.5 – 33.0	Ø33.5 – 51.0
P	Low-Carbon	80~170	(240) 160~300	0.04~0.06	0.04~0.06	0.04~0.08	0.04~0.08
	High-Carbon	170~250	(180) 140~220	0.04~0.10	0.04~0.12	0.06~0.16	0.08~0.18
	Low-alloy steel	140~260	(180) 160~250	0.04~0.10	0.06~0.12	0.08~0.16	0.08~0.18
	High-alloy steel	180~300	(160) 160~250	0.04~0.10	0.06~0.12	0.08~0.16	0.08~0.18
	Cast Steel	180~300	(160) 140~200	0.05~0.08	0.06~0.12	0.08~0.14	0.08~0.16
M	Ferritic/Marte nsitic stainless steel	150~270	(140) 120~200	0.04~0.10	0.06~0.12	0.06~0.14	0.06~0.16
	Austenitic Stainless	150~270	(140) 110~200	0.04~0.10	0.06~0.12	0.06~0.14	0.06~0.16
K	Malleable cast iron	150~230	(160) 120~220	0.04~0.10	0.06~0.14	0.06~0.16	0.08~0.20
	Grey cast iron	150~230	(180) 140~230	0.04~0.10	0.06~0.14	0.06~0.16	0.08~0.20
	Ductile iron	160~260	(160) 130~210	0.04~0.12	0.06~0.16	0.08~0.18	0.08~0.20



HONGJIANG

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