



TOOLING  
YOUR  
WORLD.



## Workholding



4" & 6" Vises . . . . .	4-5
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TOOLING  
YOUR  
WORLD.

From Spindle to Table

## Retention Knobs

A fit for every machine



## Tool Holding

Collet Chucks, Shrink Fit,  
End Mill, Shell Mill,  
Tapping Heads, Drill Chucks,  
Boring Heads,  
Right Angle Heads



## Collets

ER Collets, TG Collets,  
DA Collets, 5C Collets, R8  
Collets, Milling Chuck Collets



## Cutting Tools

End Mills, Drills,  
Taps, Indexables and  
Indexable Holders



## Measuring & Inspecting

Calibration, Layout & Machine Setup,  
Dimensional Measuring Tools



## Workholding

Vises, Live Centers, Lathe Chucks,  
Clamping Kits, Fixturing



A holder for every application.  
What's your combo?



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GS160 6" Precision  
Milling Machine Vise  
327320



**NEW!**

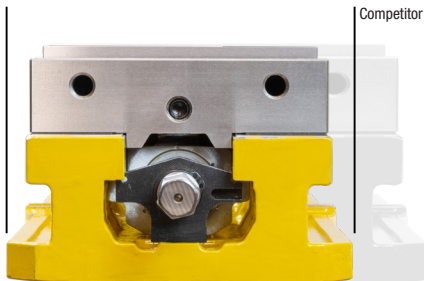
GS100 4" Precision  
Milling Machine Vise  
327319



# Get the Most Out of **Your Workspace**

With the **GS100G** 4" Precision Milling Machine Vise,  
a smaller version of the 6" Vise we know you love.

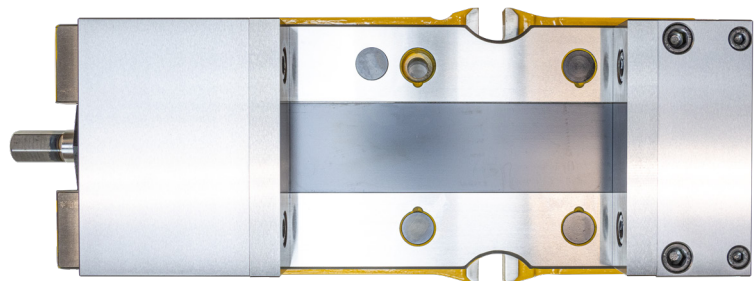
**10 YEAR  
WARRANTY**



## NARROW BODY STYLE\*

to allow more vises on a machine table.

\*compared to the competition



## HOLD DOWN BOLT HOLES

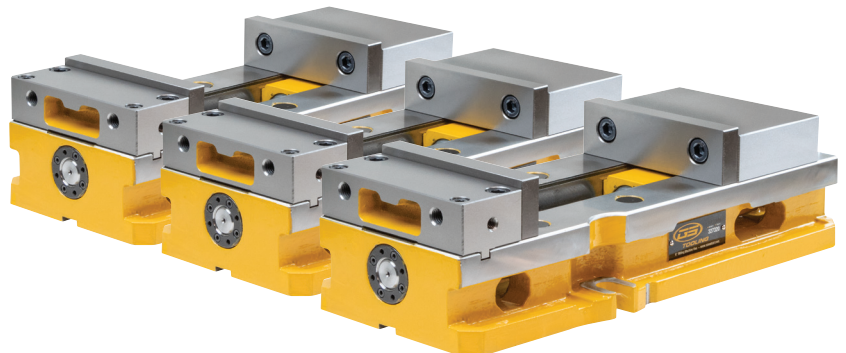
allow for easy side by side mounting of multiple vises on a table.



A larger, more durable

## BEARING PACK

that does not protrude from  
the end of the vise body.



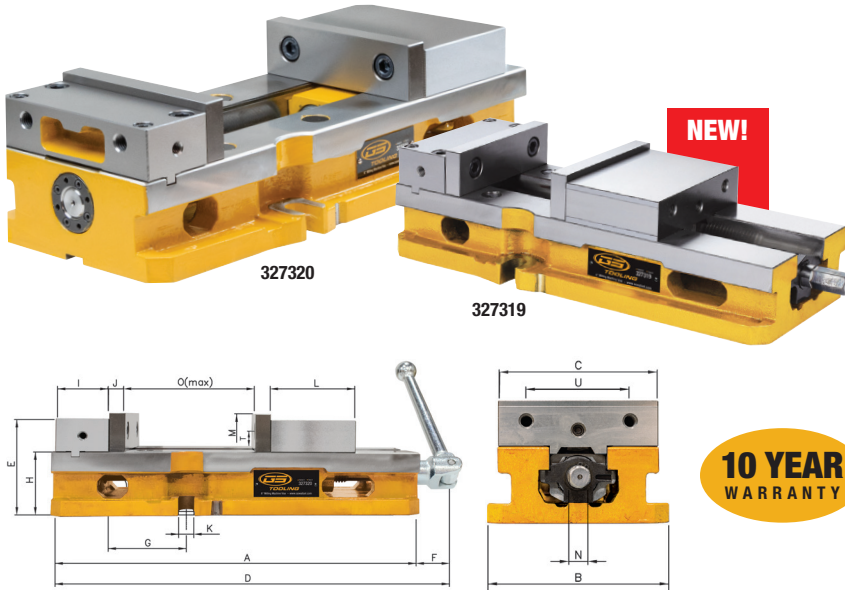
## MATCHED BED HEIGHTS within $\pm 0.0005"$

allow for multiple vises to be easily used in parallel.

## GS100G 4" & GS160G 6" Precision Milling Machine Vises

- Larger, more durable **bearing pack** engineered to deliver a highly stable workholding system that is stronger under pressure.
- A new brush seal design **keeps debris from penetrating the nut** due to a more efficient **chip evacuation system** through both the body and ends of the vise, while not compromising on the strength of the body.
- Spherical Segment creates an **all directional alignment** and **reduces jaw lift** of the movable jaw, while the 4-bolt design of the fixed jaw enables **stable clamping**.
- Reduced stress on body** as a result of the pull-type design features also includes a **spindle nut that does not protrude** past the end of the body during clamping.

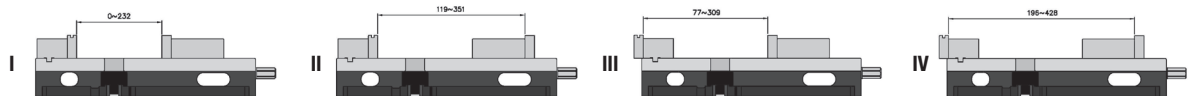
Newly redesigned,  
**GS TOOLING**  
**GS100G &  
GS160G Vises**  
are packed with industry-leading  
workholding features.



Part Description	GS100G Code No.	GS160G Code No.
#2 Main Screw	327321	327322
#4 Sliding Spindle Nut	327323	327324
#5 Movable Jaw	327325	327326
#6 Fixed Jaw	327327	327328
#7 Jaw Plate (2pcs)	327329	327330
<b>Repair Kit</b> - Consists of #8 segment, #20 bearing, #21 o-ring, 2pc #10 brush, 2pc #19 c-clip	327331	327332
<b>Handle Assembly</b> - Consists of #11 socket, #12 bar, #13 pin	327333	327334
#14 Slide Cover (Back)	327335	327336
#14 Slide Cover (Front)	-	327338
#16 Bolt for Jaw Plate (Piece)	327339	327340
#17 Bolt (Long) for Fixed Jaw	327341	327342
#18 Bolt (Short) for Fixed Jaw	327343	327344

(Inch)																			
Model	A	B	C	D	E	F	G	H	I	J	K	L	M	N	O	T	U	Weight	Code No.
GS100G	12.5	5	4	13.7	3.37	1.14	2.56	2.25	1.75	0.55	0.5	3.1	1.24	0.55	6.5	0.69	2.5	30.86lbs	327319
GS160G	16.8	7.3	6	18.4	4.37	1.54	3.56	2.875	2.31	0.725	0.725	4	1.75	0.75	9.1	0.94	3.875	68.34lbs	327320

### Capacity



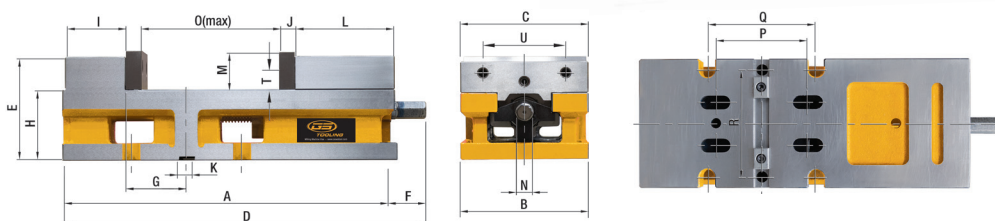
	I				II				III				IV			
	GS100G				GS160G				GS100G				GS160G			
	6.5"				3.65~10.18"				2.3~8.83"				5.95~12.48"			
	166mm				92.7~250.7mm				58.45~224.45mm				151.15~317.15mm			
	0~9.1"				4.68~13.82"				3.03~12.16"				7.72~16.85"			
	0~232mm				119~351mm				77~309mm				196~428mm			

## GSV60 6" Versatile Vise

- 6" vise with 6-1/2" opening
- High accuracy vise for single station CNC centres specially designed to prevent workpiece lift
- 2 operating positions for Vertical Machine Centres: Upright & Lay Down
- 1 operating position for Horizontal Machine Centres: Horizontal
- Bed height: 81mm  $\pm 0.012$ mm (3.189"  $\pm 0.0005$ ")
- Material: FCD-60
- Weight: 68lbs / 31kg



### LIFETIME WARRANTY!



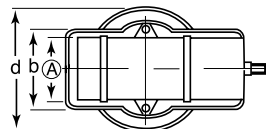
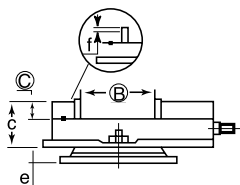
A	B	C	D	E	F	G	H	I	J	K	L	M	N	O	P	Q	R	T	U	Weight	Code No.
385	152.45	151	431.8	118.7	46.8	69.84	81	69.9	18	18	114.3	44.5	19	163	107.95	127	127	23.8	98.4	31kg	382620



## GS675 6" Precision Milling Machine Vise



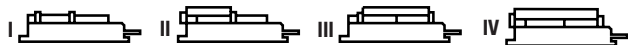
- Vises are matched (Bed Height: 2.875")
- An integral key and large fasteners reduce deflection by 50%
- 4-jaw plate positions allow extra capacity with the jaw plates in the outside position
- The swivel base is graduated 360° in one degree increments
- Chip cover protects leadscrew from damage
- The quality movable jaw does not lift off the bed, and the deflection of the stationary jaw is minimized



(Inch)

Model	Jaw Width A	Jaw Open B	C	O.A.L.	b	c	d	e	f	Plain Ship Wt	Code No.
GS675	6	7.5	1.77	17.2	9.13	4.6	12	1.65	0.39	80lbs	327275M
Jaw Plates (2pcs)											327330
Swivel Base Only											327280
Replacement Handle											327334
Main Screw, Collar & Collar Set Screw for GS675											327284
Chip Cover											327338
Vise Nut for GS675											327288
Jaw Plate Screws (4pcs)											327286
Ball Bearing Thrust Collar											327292

### Capacity

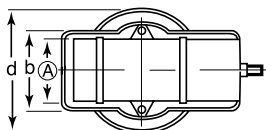
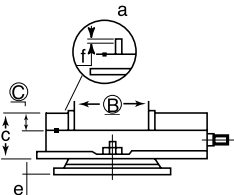


	I	II	III	IV
GS 675	0-7-1/2" 0-192mm	2-1/8" - 10-1/4" 54-262mm	5" - 13-1/8" 125-333mm	7" - 15-7/8" 177-403mm
GS 810	0-10.43" 0-265mm	2.36" - 3.66" 60-347mm	6.25" - 16.61" 159-422mm	8.58" - 20.79" 218-528mm

## GS810 8" Precision Milling Machine Vise



- Vises are matched (Bed Height: 3.310")
- An integral key and large fasteners reduce deflection by 50%
- 4-jaw plate positions allow extra capacity with the jaw plates in the outside position
- The swivel base is graduated 360° in one degree increments
- Chip cover protects leadscrew from damage
- The other quality movable jaw does not lift off the bed, and the deflection of the stationary jaw is minimized



(Inch)

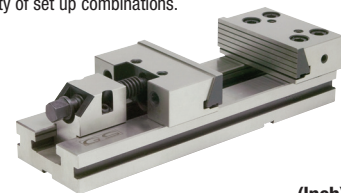
Model	Jaw Width A	Jaw Open B	C	O.A.L.	b	c	d	e	f	Plain Ship Wt	Code No.
GS810	8	10.0	2.25	21.8	11.62	5.55	15.0	1.85	0.43	158lbs	327300
Swivel Base Only											327310
Jaw Plates											327311
Replacement Handle											327305

## GS Plain Base Modular Vises



Manufactured under rigid quality control. As a result of the high standard construction, GS Vises can be depended upon to maintain their accuracy under the most severe operating conditions. The modular design and the concept of interchangeability makes possible a wide variety of set up combinations.

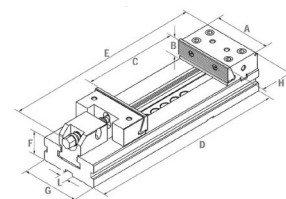
- High accuracy
- Unlimited clamping range
- High quality alloy steel
- High clamping pressure
- No jaw lift
- All vises are matched



(Inch)

Model	Jaw Width (A)	Opening (C)	Jaw Height (B)	Code No.
1	4	4	1.2	382005
2	5	6	1.6	382010
3	6	8	1.97	382015
3	6	12	1.97	382017
4	7	8	2.4	382020
4	7	12	2.4	382025
4	7	16	2.4	382030
4	7	20	2.4	382032
5	8	8	2.6	382035
5	8	12	2.6	382040
5	8	16	2.6	382045
5	8	20	2.6	382050
5	8	24	2.6	382052
6	12	8	3.2	382055
6	12	12	3.2	382060
6	12	16	3.2	382065
6	12	20	3.2	382070
6	12	24	3.2	382075
6	12	28	3.2	382080
6	12	32	3.2	382085

### Modular Vise Specs



(Inch)

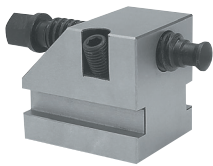
Vise Size	Code No.	D	E	F	G	H	I	Kgs
4 x 4	382005	10.63	12.5	1.378	2.95	3.07	0.628	6.8
5 x 6	382010	13.583	16.4	1.575	3.8	3.04	0.64	12.9
6 x 6	382015	16.535	20.86	1.968	4.92	3.574	0.64	25.5
6 x 12	382017	20.472	20.86	1.968	4.92	3.574	0.64	29
7 x 8	382020	17.913	24.80	2.283	5.8	3.876	0.64	37
7 x 12	382025	21.85	24.80	2.283	5.8	3.876	0.64	42
7 x 16	382030	25.787	24.80	2.283	5.8	3.876	0.64	47
7 x 20	382032	29.724	24.80	2.283	5.8	3.876	0.64	52
8 x 8	382035	19.488	28.74	2.756	6.8	4.536	0.64	64
8 x 12	382040	23.425	28.74	2.756	6.8	4.536	0.64	69
8 x 16	382045	27.362	28.74	2.756	6.8	4.536	0.64	74
8 x 20	382050	31.299	28.74	2.756	6.8	4.536	0.64	79
8 x 24	382052	35.236	28.74	2.756	6.8	4.536	0.64	84
12 x 8	382055	21.063	32.67	3.07	7.67	4.74	0.64	95
12 x 12	382060	25.000	32.67	3.07	7.67	4.74	0.64	105
12 x 16	382065	28.937	32.67	3.07	7.67	4.74	0.64	115
12 x 20	382070	32.874	32.67	3.07	7.67	4.74	0.64	125
12 x 24	382075	36.811	32.67	3.07	7.67	4.74	0.64	135
12 x 28	382080	40.748	32.67	3.07	7.67	4.74	0.64	145
12 x 32	382085	44.685	32.67	3.07	7.67	4.74	0.64	155

### Parts For GS 8" Precision Milling Machine Vises



Description	Code No.
Main Screw, Collar & Collar Set Screw	327306
Ball Bearing Thrust Collar	327292
Needle Bearing Thrust Collar	327307
Chip Cover	327308
Vise Nut	327309
Jaw Plate Screws (4pcs)	327312

## Parts & Accessories For GS Modular Vises



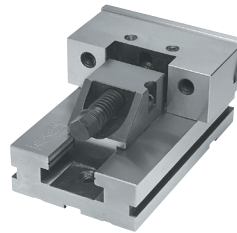
Mechanical  
Blocking Device



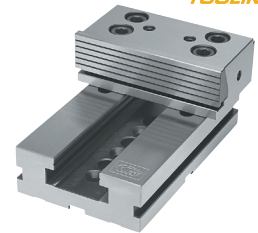
Swivel Base



Extension Base



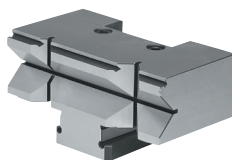
Moveable Jaw  
Section and Base



Fixed Jaw Section  
and Base

Part Description	#1 Code No.	#2 Code No.	#3 Code No.	#4 Code No.	#5 Code No.	#6 Code No.
Swivel Base	382380	382385	382390	382395	382400	382405
Extension Base	382260	382265	382270	382275	382280	382285
Mechanical Blocking Device	382470	382475	382480	382485	382490	382495
Moveable Jaw	382412	382417	382422	382427	382432	382437
Fixed Jaw	382410	382415	382420	382425	382430	382435
Main Screw	382850	382852	382854	382856	382859	382860
T-Wrench	382820	382822	382824	382826	382828	382830
Box Wrench	382874	382876	382878	382880	382882	382884
Vise Holding Jaws (Pair)	382685	382690	382695	382700	382705	382710
Positioning Keys	382655	382660	382665	382670	382675	382680
Work Stop	382770	382775	382780	382785	382790	382795
Jaw Plate for Fixed Jaw	382862	382864	382866	382868	382870	382872
Jaw Plate for Moveable Jaw	382863	382865	382867	382869	382871	382873
Lock Screw for Blocking Device	382471	382476	382481	382486	382491	382496
	M6x1 x 25mm	M12x1 x 25mm	M14x2 x 35mm	M12x1.75 x 40mm	M20x2.5 x 60mm	M20x2.5mm x 50mm
	382472		382482			
	M8x1.25 x 25mm		M12x1.75 x 30mm			
Chrome Locking Ball for Blocking Device	382473 9/16" dia.					
<b>Pre-Assembled Groups</b>						
<b>Overall Length</b>	5.5"	6.30"	9"	10"	12"	13.75"
<b>Leadscrew Overhang</b>	2.08"	2.3"	2.8"	2.0"	3"	2.16"
Moveable Jaw Section and Base Assembly	382290	382295	382300	382305	382310	382315

## Prismatic Jaws



Model No.	Code No.
#3	382890
#4	382892
#5	382894

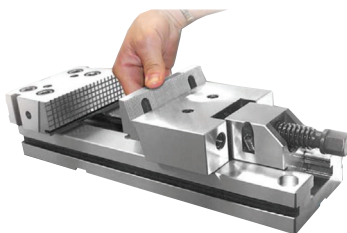
## Modular Vise w/ Quick Interchangeable Pulldown Jaws



No tools needed for quick hand change of downward jaw plates



Soft Jaws

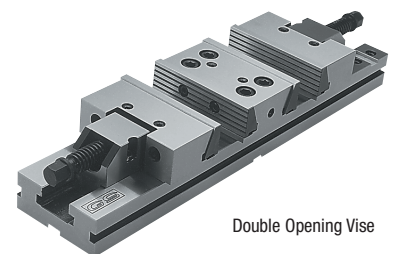


Description	Code No.
6 x 8 Modular Vise	382896
Pair Soft Jaws	382897

## GS Modular Vises — Single & Double Opening



- High accuracy
- No length limitations
- Unlimited clamping range
- No jaw lift
- High quality alloy steel
- Low profile
- High clamping pressure
- All vises are matched
- Mechanical and pneumohydraulic blocking devices
- Extra long base



Double Opening Vise

Model	Opening	O.A.L.	Jaw Width	Weight (kg)	Code No.
<b>Single Opening Modular Vise</b>					
1	11.4	18	4	10	382101
2	12.6	20.5	5	17	382102
3	14.7	23	6	31	382103
3	18.11	27	6	34	382104
4	16	26	7	46	382105
4	20	30	7	51	382106
5	24	36	8	92	382110
<b>Double Opening Modular Vise</b>					
3	2 x 4.3	23	6	38	382153
3	2 x 6.3	27	6	41	382154
4	2 x 6.7	30	7	63	382156
5	2 x 10	40	8	107	382172
6	2 x 6.3	35	12	154	382175
6	2 x 16	55	12	194	382180

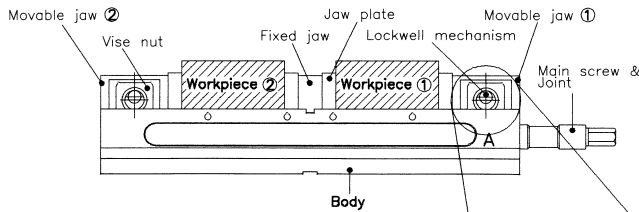


## Double Clamp Vise

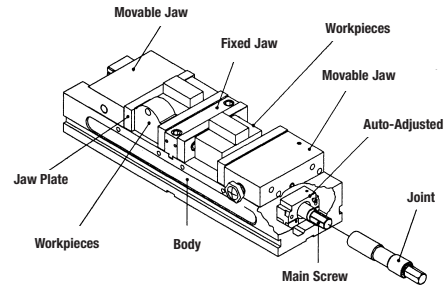
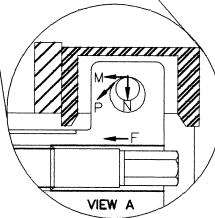
- Double clamp set - one handle can simultaneously operate two moveable jaws and clamps 2 workpieces of same or different size or one large workpiece
- This model can increase efficiency and productivity of CNC machines
- The movable jaw ANTI-LIFT mechanism provides alignment to workpiece without jaw lift
- There are 6 kinds of clamping ways to meet workpieces of different shapes and sizes
- The whole body is precisely ground and height tolerance is within  $\pm 0.025\text{mm}$  ( $\pm 0.001''$ ), therefore several vises can be lined up for production
- The vise is made of FDC-80.000 psi (55kg/cm<sup>2</sup>) Ductile iron, and slide ways are hardened to 45HRC
- The rigid construction prevents base distortion
- Precision made to high accuracy standard

Model No.	Code No.
4" - TLD-40G/HV	382610
6" - TLD-60G/HV	382600

## ANTI-LIFT MECHANISM



- Clamping force equalization and ANTI-LIFT mechanism features virtually eliminate the deflection of fixed centre jaw and movable jaw lift
- Clamping range for clamping 2 workpieces simultaneously is 125 mm (4.9") each or 275 mm (10.8") for one large workpiece
- Double clamp seat



GS Double Clamp Vise  
(TLD-40G/HV, TLD-60G/HV)

### ANTI-LIFT Mechanism

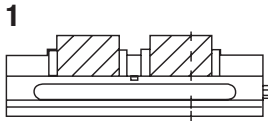
M: Jaws forward movement force

N: Gravity

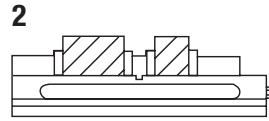
P: Resultant 45° component force forces the workpiece down while clamping

F: Direction of jaw movement

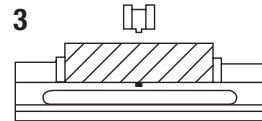
## Clamping Examples For Different Applications:



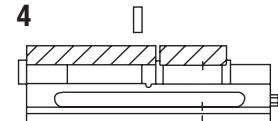
Clamping 2 pieces of same size workpieces.  
Max. Capacity: 90mm (3.5")  
125mm (4.9")



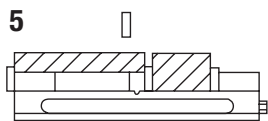
Clamping 2 pieces of different size of workpieces.  
Max. Capacity: 90mm (3.5")  
125mm (4.9")



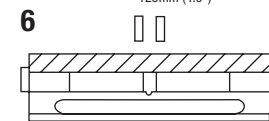
Large workpieces are able to be clamped after moving fixed jaw.  
Max. Capacity: 237mm (9.3")  
1315mm (12.4")



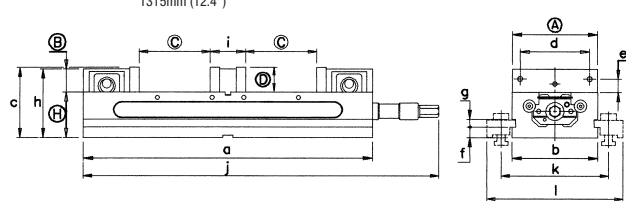
Stepped jaw plate for thin workpiece.  
Max. Capacity: 215mm (8.4")  
275mm (10.8")



Clamping 2 different workpieces.  
Max. Capacity: 215mm (8.4")  
275mm (10.8")



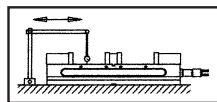
Large thin workpiece is able to be clamped after removing jaw plate on fixed jaw.  
Max. Capacity: 405mm (15.9")  
520mm (20.5")



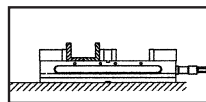
## Dimensional Information For Double Clamp Visers:

Model No.	A	B	C	D	a	b	c	d	e	f	g	h	H	i	j	k	l	Guide Block	Weight (kg/lb)
TLD-40G	103	33	90	38	405	104	101.5	63.5	17.5	13	31	96.5	63.5	55	430	143	195	18	20
(TLD-40HV)	4.05	1.29	3.54	1.49	15.9	4.09	3.99	2.5	0.68	0.51	1.22	3.79	2.5	2.16	16.9	5.62	7.67	0.709	44
TLD-60G	152	41.5	125	44.5	520	154	123.5	98.42	23.8	18	16	126.5	82.55	64	639	193	245	18	48
(TLD-60HV)	5.98	1.6	4.9	1.75	20.47	6	4.98	3.87	0.94	0.7	0.63	4.86	3.25	2.52	25.15	7.59	9.64	0.709	105.6

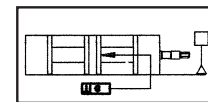
## TLD-40G, TLD-60G; match vise, TLD-40HV, TLD-60H (horizontal and vertical 2 way) Inspection Specification:



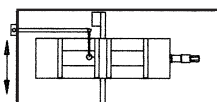
1 Parallelism: running face to bottom of bed.  
Guaranteed: 0.01 mm (0.0004")



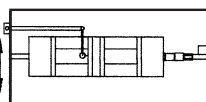
2 Squareness: between running face and jaw plate.  
Guaranteed: 0.03 mm (0.0012")



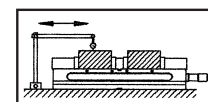
3 Squareness both sides to fixed jaw plate.  
Guaranteed: 0.02 mm (0.0008")



4 Parallelism: keyways on bottom of bed to jaw plate.  
Guaranteed: 0.02 mm (0.0008")



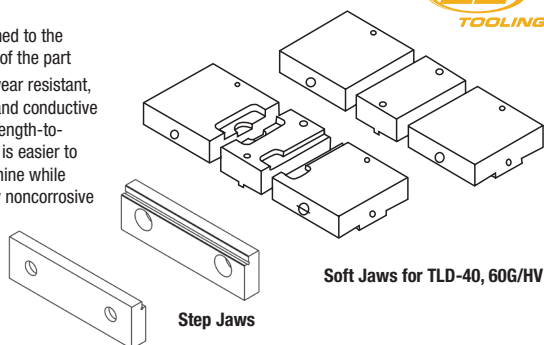
5 Squareness: keyways on bottom of bed to jaw plate.  
Guaranteed: 0.02 mm (0.0008")



6 Parallelism: running face of the test block to bottom.  
Guaranteed: 0.02 mm (0.0008")

## Machinable Fixture Jaws

- Can be machined to the precise shape of the part
- Aluminum is wear resistant, nonmagnetic and conductive with a high strength-to-weight ratio. It is easier to form and machine while being naturally noncorrosive



Description	Code No.
4" aluminum soft jaws	382612
4" step jaws	382614
6" aluminum soft jaws (10mm key)	382602
6" aluminum soft jaws (14mm key)	382609
6" step jaws	382604

## Steel Jaw Plate Set

Steel offers high tensile strength and corrosion resistance.



Description	Code No.
6" steel jaw plate set (4pcs) for TLD60	382617

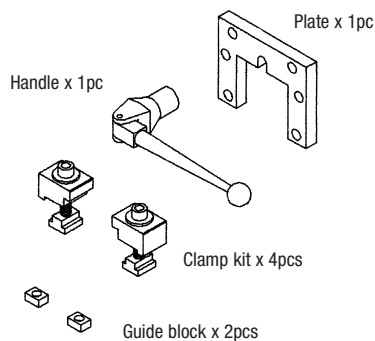
## Steel Jaw Sets

Steel offers high tensile strength and corrosion resistance.

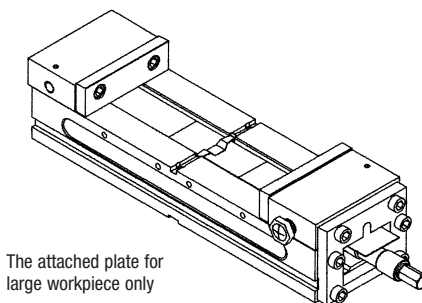


Description	Code No.
4" steel jaw set for TLD40	382615
6" steel jaw set for TLD60	382605

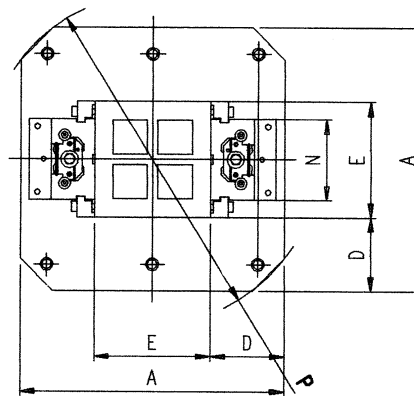
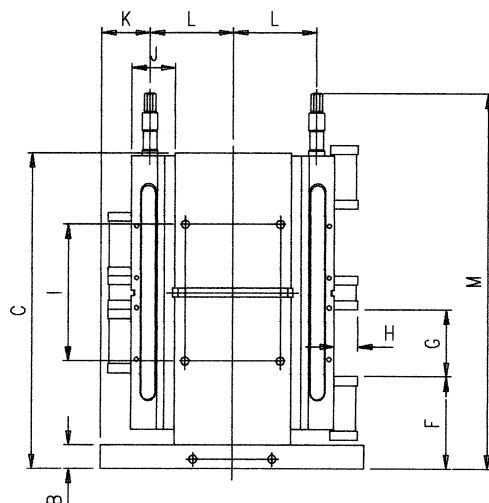
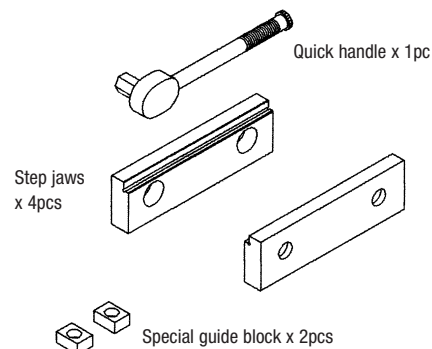
## Standard Accessories



## Usage of "Plate"



## Optional Accessories



## Jig Block Dimensional Specifications

Model NO.	Use Vise	Pallet Size	A	B	C	D	E	F	G	H	I	J	K	L	M	N	P	Weight (kg/lb)
GS-40-4C	TLD-40	400 x 400	400	40	500	110	180	168	90	38	203	63.5	75.5	124.5	543	104	506	118
GS-40-4C	TLD-40	400 x 400	15.74	1.57	19.68	4.33	7.08	6.61	3.54	1.49	7.99	2.5	2.907	4.90	21.3	4.09	19.92	259.6
GS-60-4C	TLD-60	500 x 500	500	45	600	140	220	175	125	44.5	260	82.5	92	158	714	154	628	233
GS-60-4C	TLD-60	500 x 500	19.68	1.77	23.62	5.51	8.66	6.88	4.92	1.75	10.23	3.25	3.62	6.25	28.11	6.02	24.72	512.6



## GS Multi-Tasking Modular Vises for 5-Axis Machining Centers

The MULTI-TASKING range of vises has been specially designed for 5-axis machines. Working on 5 sides of the workpiece, it allows the best optimization of the machining cycle. Thanks to the compact design this kind of vise can be installed on all machining centres. The use of GRIP jaws is strongly recommended with multitasking vises.

- Self-centering or eccentric
- Eccentric jaw adjustment in steps of 2mm
- Highest accuracy in positioning and alignment ( $\pm 0.02\text{mm}$ ) due to ground rack teeth on both the base and the fixed jaws
- Minimum deflection
- Solid, rigid construction and maximum clamping ratio to the total length
- Positioning through ground holes or keyways
- All case hardened to 60HRC for durability

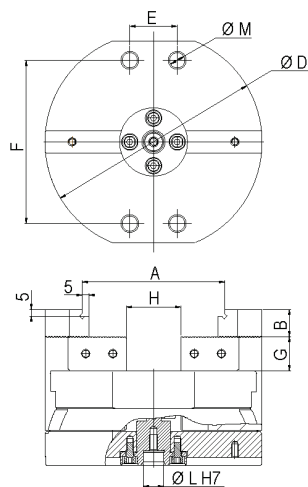


**Type 1 & 2**

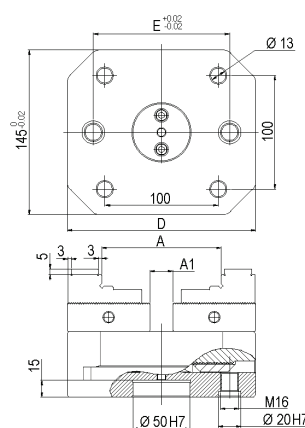
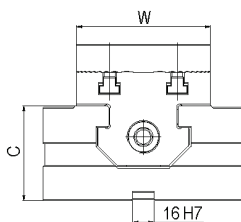


**Type 3**

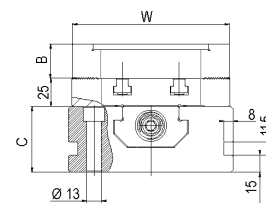
Vise shown with riser



**Type 1 & 2**



**Type 3**



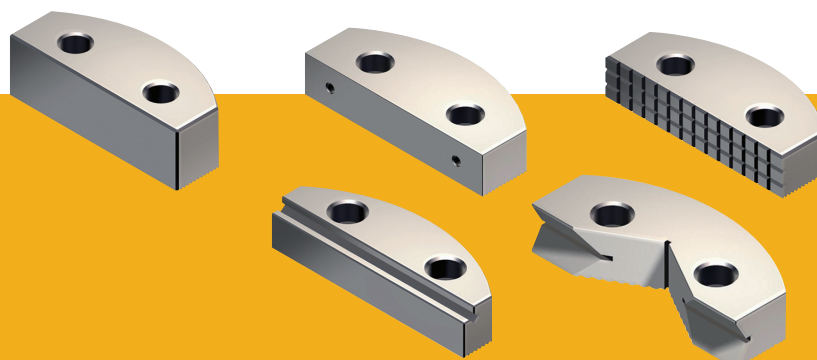
	Type 1	Type 2	Type 3x166	Type 3x266
<b>Code No.</b>	<b>382520</b>	<b>382522</b>	<b>382524</b>	<b>382526</b>
A	74	104	108	208
A1	-	-	20	60
W	74	99	138	138
B	15	20	30	30
C	50	70	58	58
ØD/D	120	160	166	266
E	5	35	120	200
F	92	120	-	-
G	20	25	-	-
H	20	40	-	-
ØL H7	20	20	-	-
M	9	11	-	-
kg	4.9	11	13	20
kN	16	20	30	30



**Also available:**

Smooth, Soft, Serrated, Step,  
Prismatic, and Grip Jaws

**Call for more information**



## Steel Risers

Allow greater access to machine hard to reach areas of the workpiece

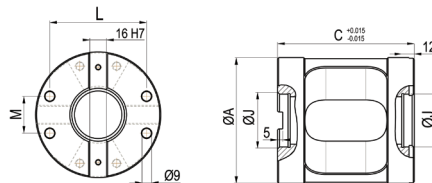


Type 1

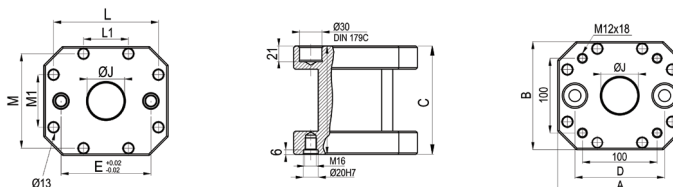


Type 3 x 166

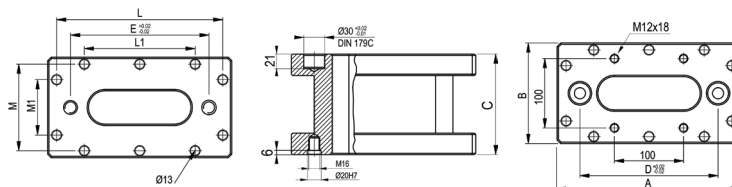
Type 1 & 2



Type 3 x 166



Type 3 x 266



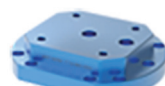
Model	A	B	C	D	E	L	L1	M	M1	ØJ	kg	Code No
Type 1	119	-	130	-	-	92	-	35	-	50 H7	6	382521
Type 2	158	-	130	-	-	120	-	35	-	50 H7	10	382523
Type 3x166	166	145	145	120	120	140	60	126	70	50 H7	14	382525
Type 3x266	266	125	145	200	200	240	160	125	80	-	21.5	382527

## Aluminum Risers

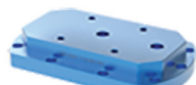
Allow greater access to machine hard to reach areas of the workpiece



Type 1 & 2

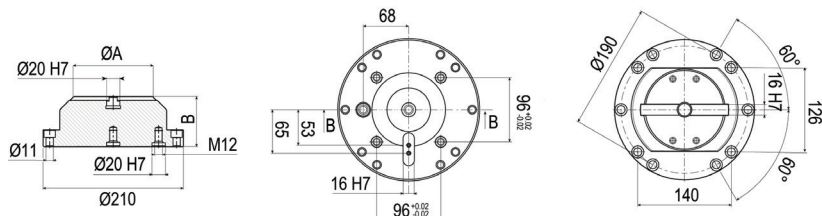


Type 3 x 166

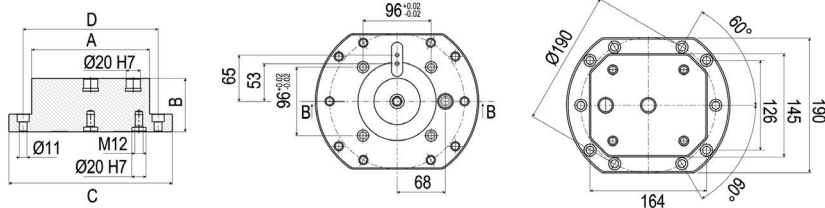


Type 3 x 266

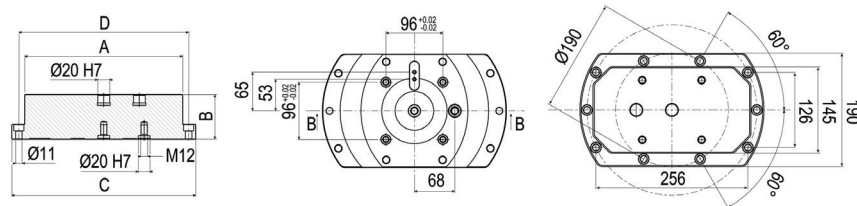
Type 1 & 2



Type 3 x 166



Type 3 x 266



Model	A	B	C	D	kg	Code No
Type 1	Ø120	50	-	-	3	382531
Type 1	Ø120	75	-	-	4.5	382532
Type 1	Ø120	100	-	-	5.4	382533
Type 2	Ø160	50	-	-	3.5	382534
Type 2	Ø160	75	-	-	4.9	382535
Type 2	Ø160	100	-	-	6.4	382536

Model	A	B	C	D	kg	Code No
Type 3 x 166	166	50	230	190	3.8	382541
Type 3 x 166	166	75	230	190	5.3	382542
Type 3 x 166	166	100	230	190	6.8	382543
Type 3 x 266	266	50	310	286	5.8	382544
Type 3 x 266	266	75	310	286	8.3	382545
Type 3 x 266	266	100	310	286	10.7	382546





## Superior performance tooling solutions when speed and accuracy matter most.

GS Tooling is an industry leader in precision tooling where high-performance and stringent quality standards are essential. Tool Your World with GS Tooling End Mill Holders, Collet Chucks & Collets, Shrink Fit Solutions, Retention Knobs, Vises & Workholding, Live Centers, Angle Heads, Carbide End Mills and more!



Shop  
GS Tooling



Tool Holding

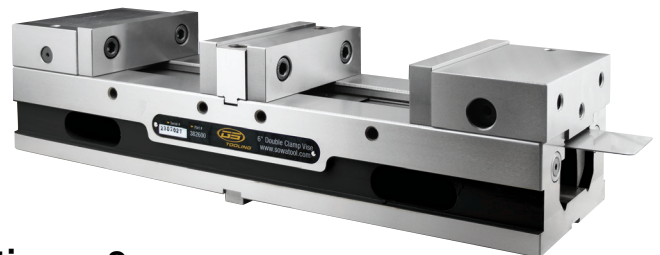


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Workholding



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