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# EASYBUILD- ASSEMBLY MANUAL

## Desktop CNC-/3D-System STEPCRAFT-2/300/420/600/840



original assembly manual  
date of 01. March 2015

Dear Customer,

Welcome to the world of STEPCRAFT! Thank you very much for purchasing our high-quality kit. This assembly manual will take you through every step of the process for your Stepcraft-2/300/420/600/840. Please read through the entire manual before starting assembly and become familiar with all the parts, hardware and notations in the manual. Doing so will help you avoid unnecessary mistakes. The more accurate you work, the better results you will have. Please be careful to note the orientation and exact position of the parts, as some might be mirror-inverted. During the manufacturing process, the thickness of the powder-coating is subject to minor tolerances. Some steps might be difficult due to the thickness of the powder coating (e.g. step 1.4, assembly of the shaft nut 59). In these cases, you may need to reduce the thickness of the coating carefully with a knife or sandpaper.

Before beginning the assembly process, please verify that you have all of the required parts in your kit using the list below. STEPCRAFT provides video support with certain assembly steps. Simply scan the related QR code with your smartphone. If you don't have a smartphone, you can simply enter: **[www.stepcraft.us/XXX-XX](http://www.stepcraft.us/XXX-XX)** (replace XXX-XX with the number under the QR code in the manual)



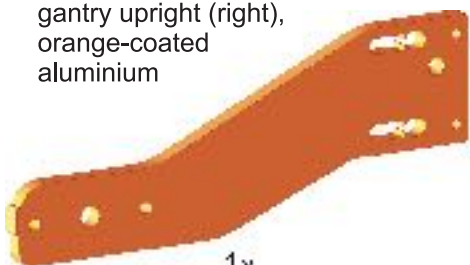
SC2-01

STEPCRAFT has taken extreme care to ensure the correctness of the information contained in this manual, however we assume no liability for any errors or omissions. We accept no liability for damage in materials or injury to persons caused by carrying out the assembly. You are responsible for the safe operation of your STEPCRAFT-CNC machine. **You must read and understand the Operating Instructions manual before you use the machine!**

#### Content of the construction kit (illustrations are not true to scale)

1

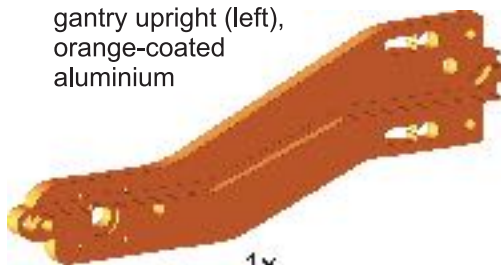
gantry upright (right),  
orange-coated  
aluminium



1x

2

gantry upright (left),  
orange-coated  
aluminium



1x

3

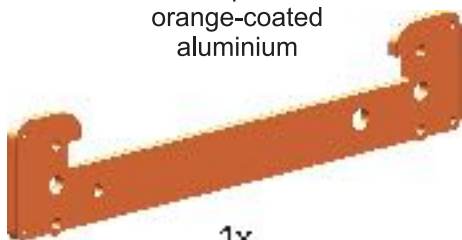
tool holder,  
orange-coated,  
aluminium



1x

4

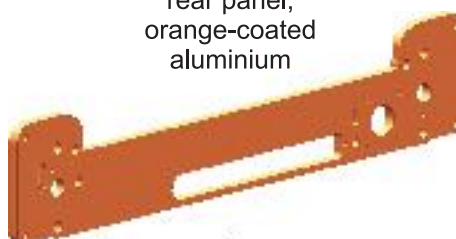
front panel,  
orange-coated  
aluminium



1x

5

rear panel,  
orange-coated  
aluminium



1x

6

X-Z-connector,  
orange-coated  
aluminium



1x

7

front panel (table restraint),  
orange-coated  
aluminium



1x

8

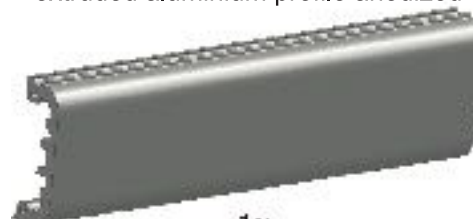
motor holder Z,  
orange-coated  
aluminium



1x

9

linear track X-axis,  
extruded aluminium profile anodized



1x

10

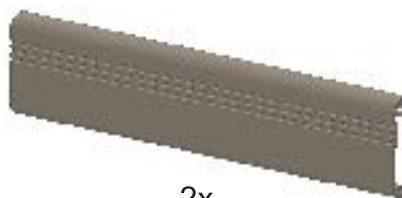
linear track Y-axis,  
extruded aluminium profile anodized



2x

11

cover Y-axis,  
extruded aluminium profile anodized



2x

12

linear track Z-axis,  
extruded aluminium profile  
anodized



1x

13

lead screw X-axis,  
round thread  $\varnothing 10 \times 3 \text{ mm}$ ,  
stainless steel



1x

14

lead screw Y-axis,  
round thread  $\varnothing 10 \times 3 \text{ mm}$ ,  
stainless steel



2x

15

plastic foot  
 $\varnothing 24,5 \times 18 \text{ mm}$



4x

16

lead screw Z-axis,  
round thread  $\varnothing 8 \times 2 \text{ mm}$ , length 182-242mm,  
stainless steel



1x

17

seal profile for Y-axis,  
silicone



S300: 1x 1520mm / S420: 1x 2000mm  
S600: 1x 2720mm / S840: 1x 3680mm

1x

18

holder ring  
 $\varnothing 8 / \varnothing 3 / 2 \text{ mm}$   
brass



4x

19

bearing 604-ZZ  
 $\varnothing 12 / \varnothing 4 / 4 \text{ mm}$   
steel



3x

20

bearing 688-ZZ  
 $\varnothing 16 / \varnothing 8 / 5 \text{ mm}$ , steel  
(in track roller bag)



32x

21

bearing 695-ZZ  
 $\varnothing 13 / \varnothing 5 / 5 \text{ mm}$   
steel



8x

22

axial-bearing  
 $\varnothing 10 / \varnothing 6 / 3 \text{ mm}$   
stainless steel



2x

23

washer  
for M3  
stainless steel



8x

24

washer  
for M4  
stainless steel



1x

25

washer  
for M5  
stainless steel



2x

26

washer  
for M6  
stainless steel



8x

27

washer  
for M8  
stainless steel



8x

28

end switch  
bracket Y-axis  
stainless steel



1x

29

end switch  
braket for X/Y,  
steel



matte 1x + 1x glossy

30

cable channel  
Y-axis



1x

31

button head cap  
screw, M3x6mm,  
stainless steel



12x

32

button head cap  
screw, M3x12mm,  
stainless steel



12x

33

button head cap  
screw, M3x16mm,  
stainless steel



4x

34

button head cap  
screw, M3x30mm,  
stainless steel



4x

35

button head cap  
screw, M4x25mm,  
stainless steel



2x

36

socket head  
screw, M3x14mm,  
steel, black



8x

37

seal ring  
ø10x1,5mm



1x

38

socket head  
screw, M5x14mm,  
steel, galvanized



6x

39

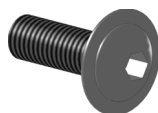
socket head  
screw, M6x20mm,  
steel, galvanized



1x

40

flange screw,  
M5x16mm,  
stainless steel



4x

41

flange screw,  
M6x10mm,  
stainless steel



12x

42

flange screw,  
M6x20mm,  
stainless steel



14x

43

flange screw,  
M6x25mm,  
stainless steel



11x

44

set screw  
M3x5mm  
steel



3x

45

set screw  
M4x4mm  
steel



4x

46

spacer, ø3/30mm,  
brass nickel-plated



1x

47

square nut  
M4  
stainless steel



1x

48

locknut M5,  
AF 10mm,  
stainless steel



2x

49

thread bolt,  
M3x15mm,  
brass nickel-plated



2x

50

spacer  
M3 I-A x13,5  
brass nickel-plated



2x

51

spacer, ø6/ø3/15mm,  
brass nickel-plated



4x

52

cable collector circle,  
ø12/ø9/6mm, brass  
(in plastic bag)



1x

53

spacer, ø11/ø8/8mm,  
brass  
(in track roller bag)



16x



54

track roller holder,  
adjustable,  
ø18x29.5mm,  
brass



4x

55

track roller holder,  
adjustable,  
ø18x33.5mm,  
brass



4x

56

track roller nut,  
AF10x20mm,  
brass



8x

57

track roller,  
ø24x15.8mm, brass  
(in track roller bag)



16x

58

axis connector X/Z,  
ø11.8/ø10/25mm,  
brass



2x

59

lead screw nut,  
RG 10x3mm,  
brass



4x

60

cable collector X,  
ø23x21mm,  
plastics, black



1x

61

cable collector Z,  
ø23x20mm,  
plastics, black



1x

62

drive pulley,  
T2.5x20  
aluminium / steel



3x

63

spring catch,  
ø8/10mm,  
plastics



4x

64

cover hinge,  
ø5/ø10/17mm,  
plastics, white



4x

65

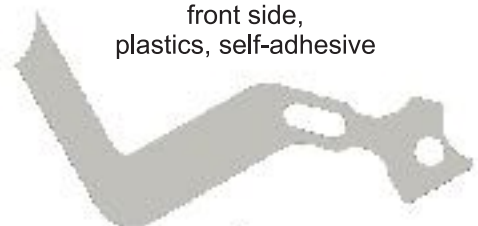
cable channel,  
rear side,  
plastics, self-adhesive



1x

66

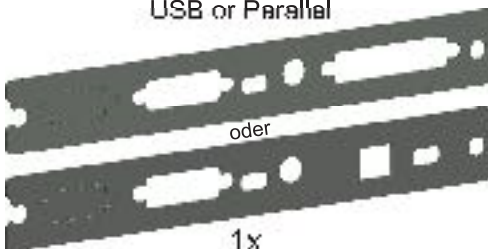
cable channel,  
front side,  
plastics, self-adhesive



1x

67

electrical equipment cover  
USB or Parallel



1x

68

cable channel,  
outside top,  
plastics,  
self-adhesive



1x

69

cable channel, outside middle,  
plastics, self-adhesive



1x

70

cable channel, outside bottom,  
plastics, self-adhesive



1x

71

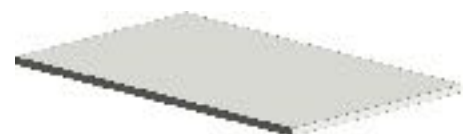
hose clip,  
steel wire



6x

72

machine table, thickness 8mm,  
high-pressure laminates



1x

73

tooth belt



S300= T2,5x600 / S420= T2,5x780  
S600= T2,5x1020 / S840= T2,5x1380

1x

74

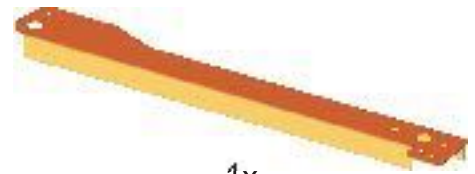
rubber grommet,  
ø8mm, black



4x

75

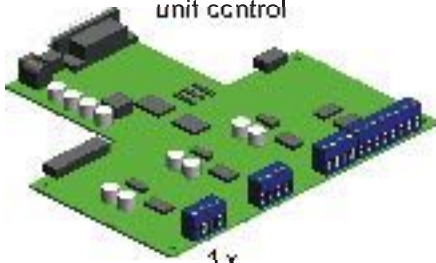
tooth belt cover orange-coated  
steel panel



1x

76

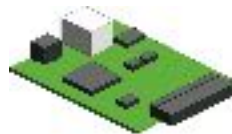
unit control



1x

77

input module  
USB or Parallel



1x

78

unit control holder,  
stainless steel panel



1x

79

bottom plate,  
steel panel galvanized



1x

80

unit control plate,  
steel panel galvanized



1x

81

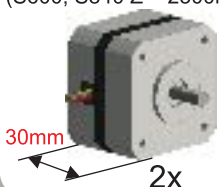
emergency switch



1x

82

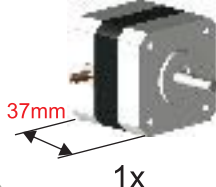
motor X-/ Z-axis  
Nanotec, 1.4 A  
length X, Z = 1400mm  
(S600, S840 Z = 2300mm)



2x

83

motor Y-axis  
Nanotec, 1.8 A  
length Y=300mm



1x

84

X-Z end switch  
connector cable



1x

85

X-Z-end  
switch cable



S300: 1x 1295mm  
S420: 1x 1405mm  
S600: 1x 1805mm  
S840: 1x 2225mm

86

Y end switch/  
emergency  
connector cable



Length:1200mm

2x

87

flexible hose  
ø7,4mm



265mm

1x

88

flexible hose  
ø10mm



S300=310mm  
S420=400mm  
S600=520mm  
S840=700mm

1x

89

flexible hose  
ø12,8mm



S300=350mm  
S420=470mm  
S600=650mm  
S840=830mm

1x

90

clamping system,  
grey-coated,  
steel panel



2x

91

end switch for  
X-,Y- and Z-axis



3x

92

closing cap,  
rubber

1x

93

self-adhesive  
film

4x

94

power supply  
110V-240V 50/60Hz  
30V, 90Watt  
Plug  $\varnothing 2.5/\varnothing 5.5$ 

1x

95

USB cable  
or  
parallel connection  
cable

1x

96

label set

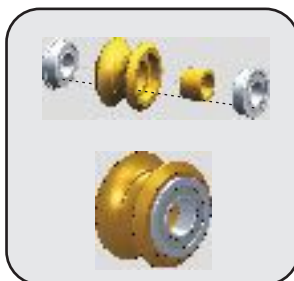
1x

97

machine lubricant



1x

**VERY IMPORTANT!**

The parts 20, 53 and 57 fit in perfectly with each other. They have been extensively measured, polished and individually wrapped. Please ensure to use only the components of one single plastic bag for the assembly of one track roller. This prevents potential interchange and assures play-free track roller and the accuracy of the complete machine.

**1:1 Comparison-Pictures**

23



washer for M3

24



washer for M4

25



washer for M5

26



washer for M6

27



washer for M8

31



M3x6

32



M3x12

33



M3x16

34



M3x30

35



M4x25

36



M3x14

37



M3x20

38



M5x16

39



M6x20

40



M5x15

41



M6x10

42



M6x20

43



M6x25

44

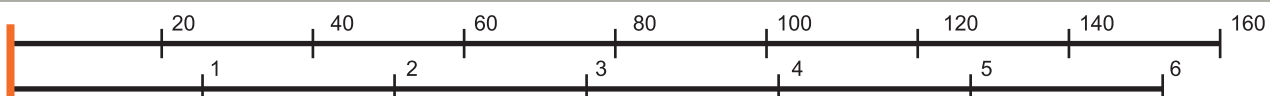


M3x5

45



M4x4

mm  
inch

### explanation of symbols and details:



= assembly group



= interim assembly group



= work step



= view of assembly group



= required parts for this work step



= larger detailed view/  
pre-assembly of parts



= fasten part with superglue, use sparingly, must not get on bearing or running surface



= apply 3-N-1 / multi-purpose oil as shown in picture



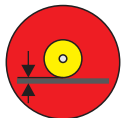
= engage the screw, but do not tighten



= tighten the screw



= play-free assembly, must run smoothly



= adjust the roller guide play-free



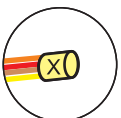
= adjust roller guide with the adjustable screw (1/4 turn) to obtain low pre-load



= part must run smoothly, if applicable remove powder coating carefully or thin part slightly e.g. with sand paper



= remove protection film and affix self-adhesive part



= bundle and label the cable head of the motor with adhesive film

### required tools and material:



- slotted-head screwdriver
- Allen wrench 1.5mm
- Allen wrench 2.0mm
- Allen wrench 2.5mm
- Allen wrench 3.0mm,
- Allen wrench 4.0mm (L-shape)
- Allen wrench 5.0mm (L-shape)
- long-nose pliers
- cutting tool

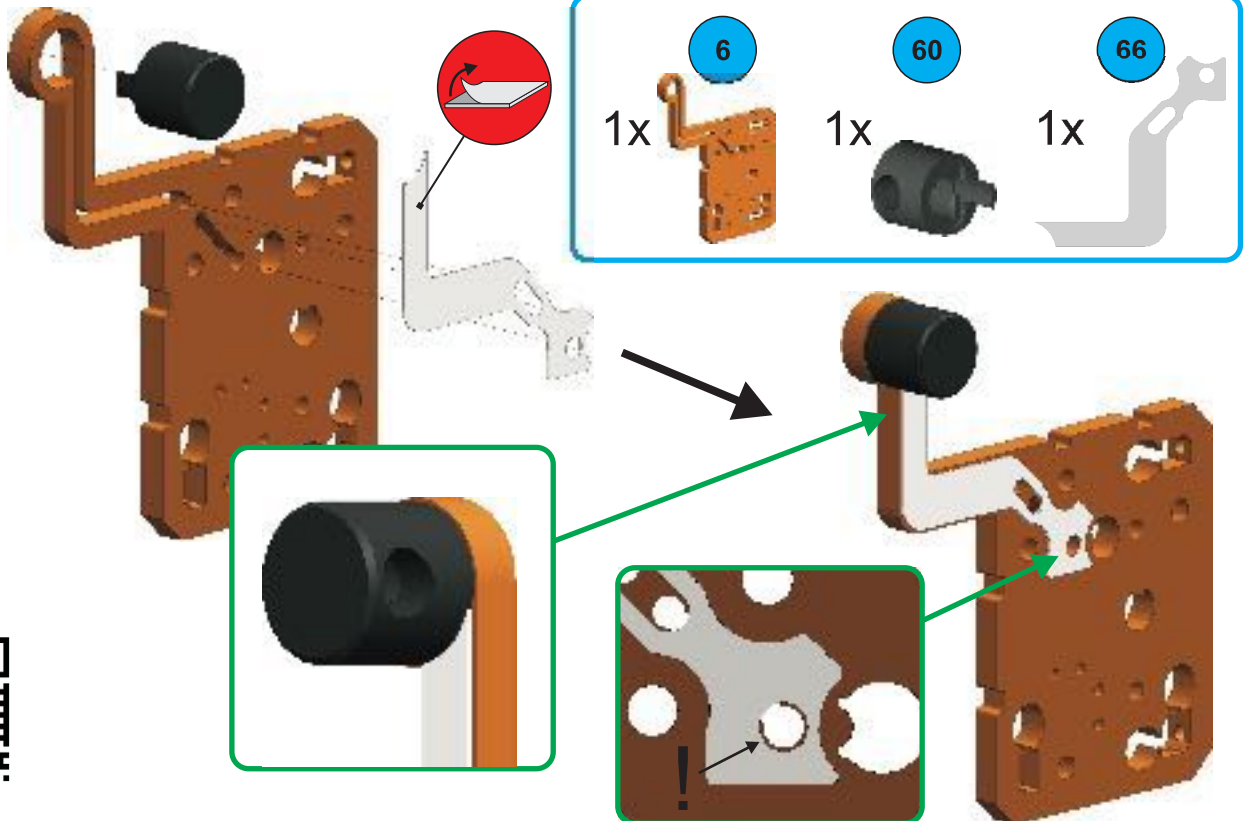
- spanner 5.5mm
- spanner 7mm
- spanner 8mm
- spanner 10mm
- superglue
- measuring tool (slide gauge)
- adhesive film
- multi-purpose oil

1



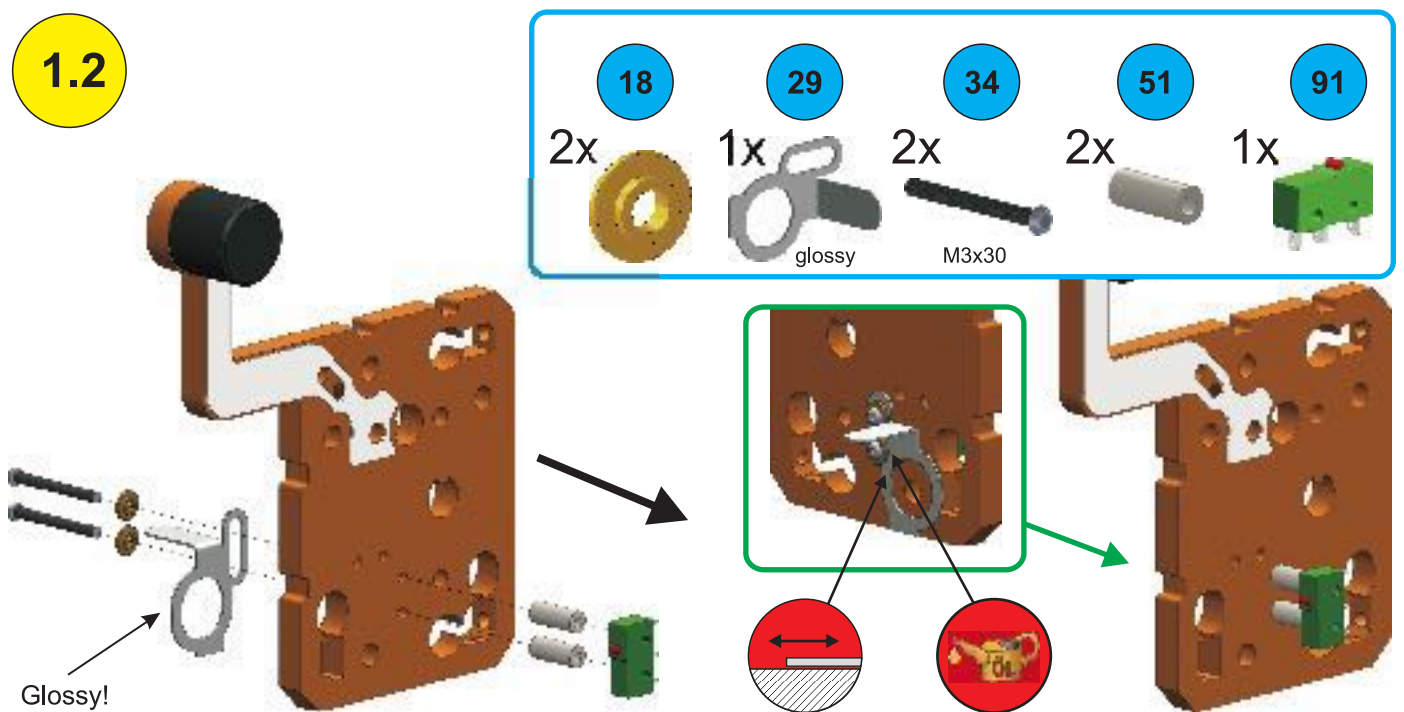
## X-Z-connector

1.1



SC2-02

1.2

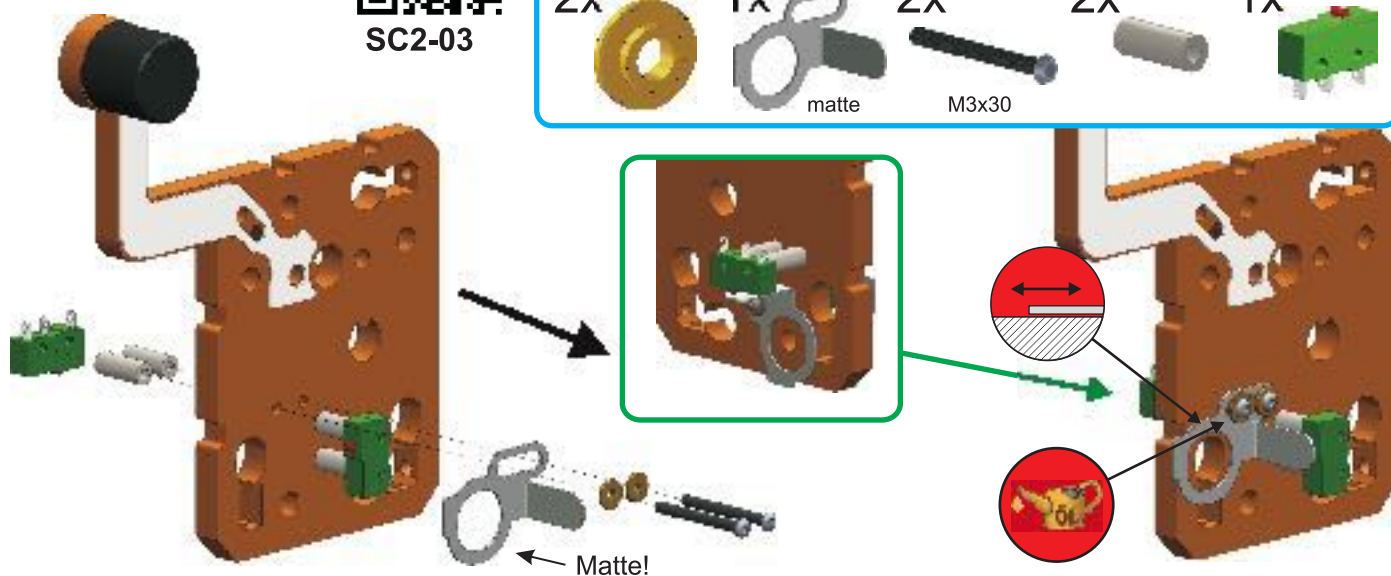
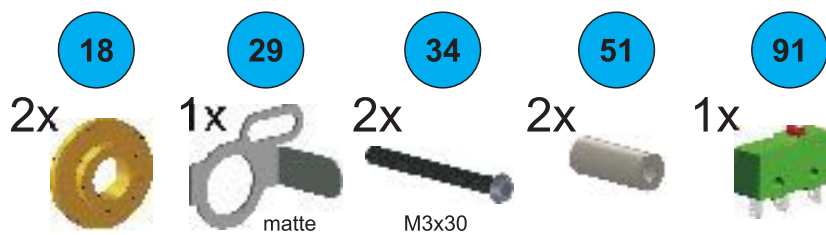




1.3

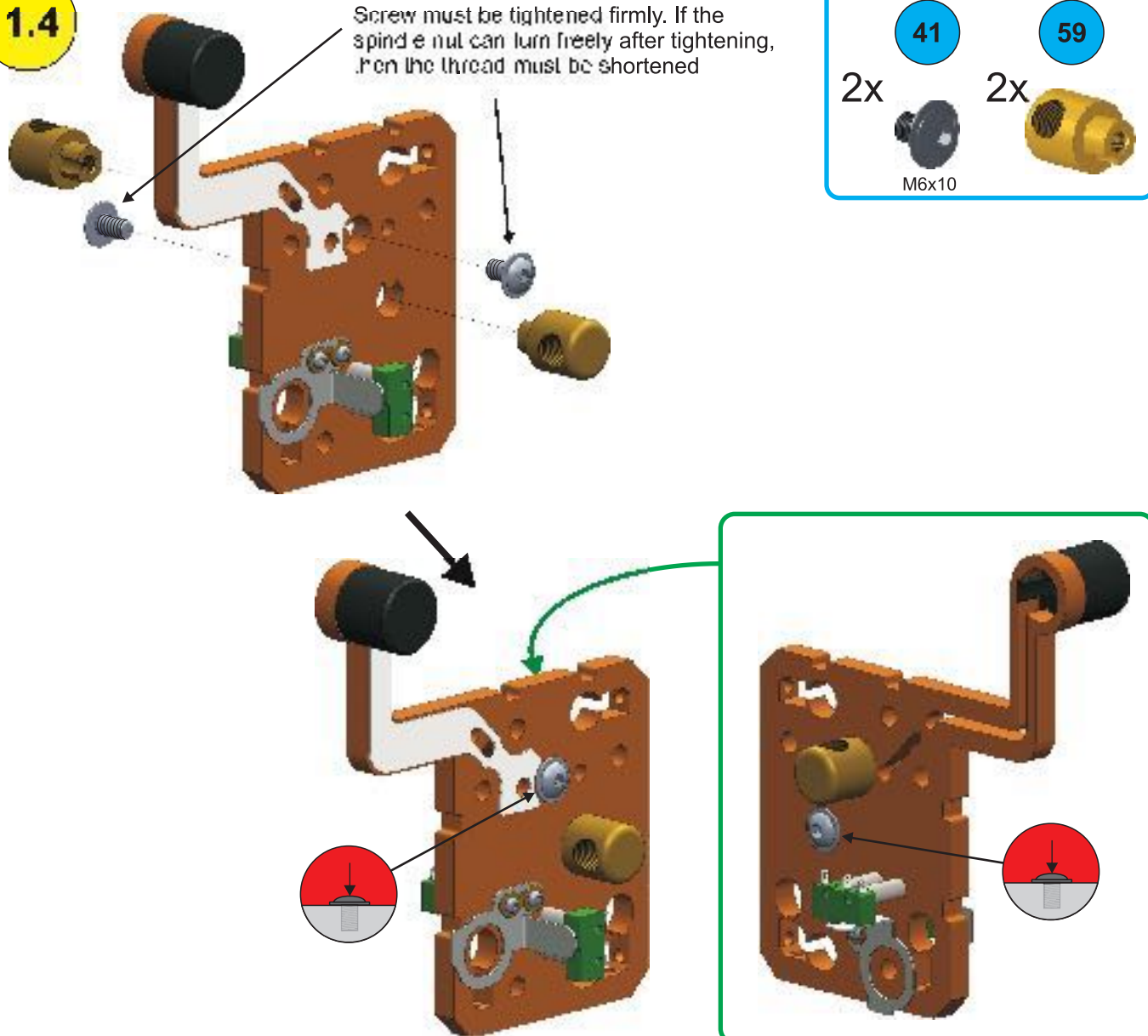


SC2-03



1.4

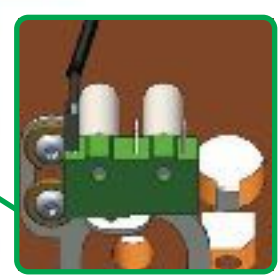
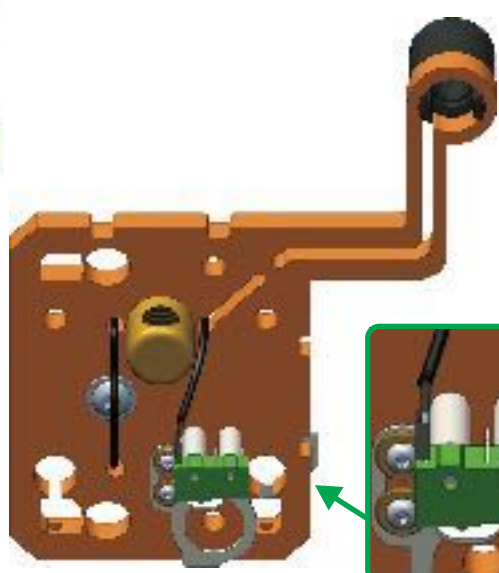
Screw must be tightened firmly. If the spindle nut can turn freely after tightening, then the thread must be shortened



1.5

84

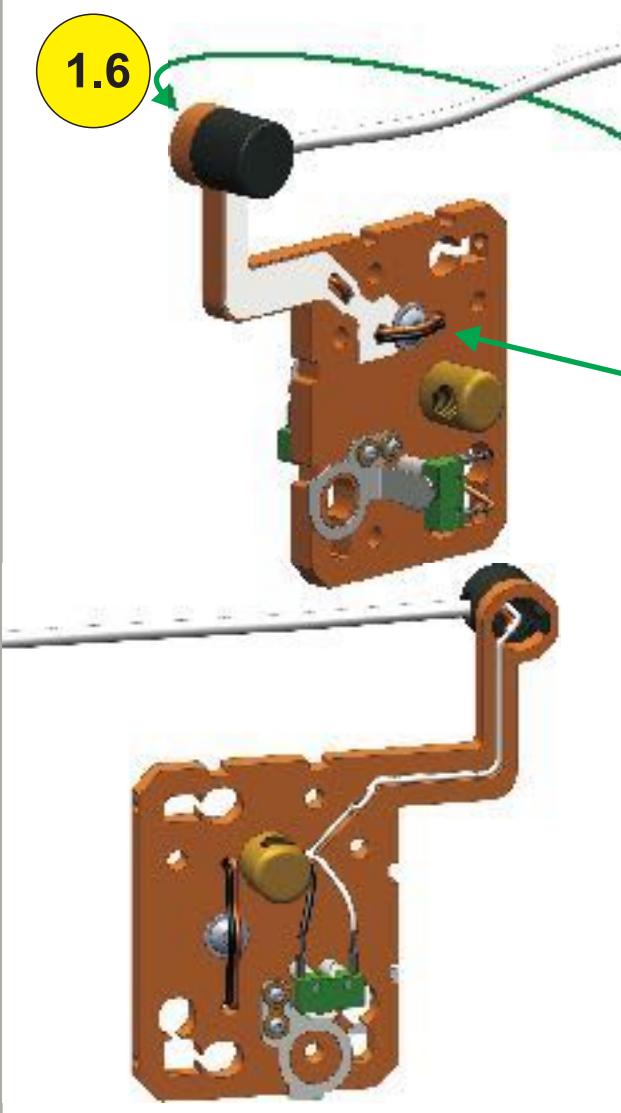
1x



1.6

85

1x



1.7

61 1x

65 1x

**1.8**

23  
2x  
for M3

36  
2x  
M3x14

42  
2x  
M6x20

54  
2x

!



1.9

Use 4 track roller bags

20

53

57

8x

4x

4x

Keep parts in each bag together!

26

27

41

56

2x

2x

2x

2x

for M6

for M8

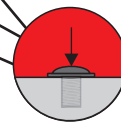
M6x10

M6x10



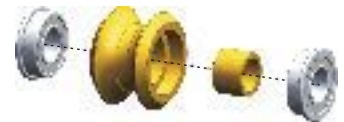
SC2-04

bend cable carefully  
away from track roller!



Use L-shape  
Allen wrench.  
Must tighten  
firmly!

4x



1.10

23

36

42

54

2x

2x

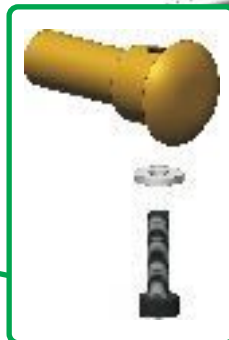
2x

2x

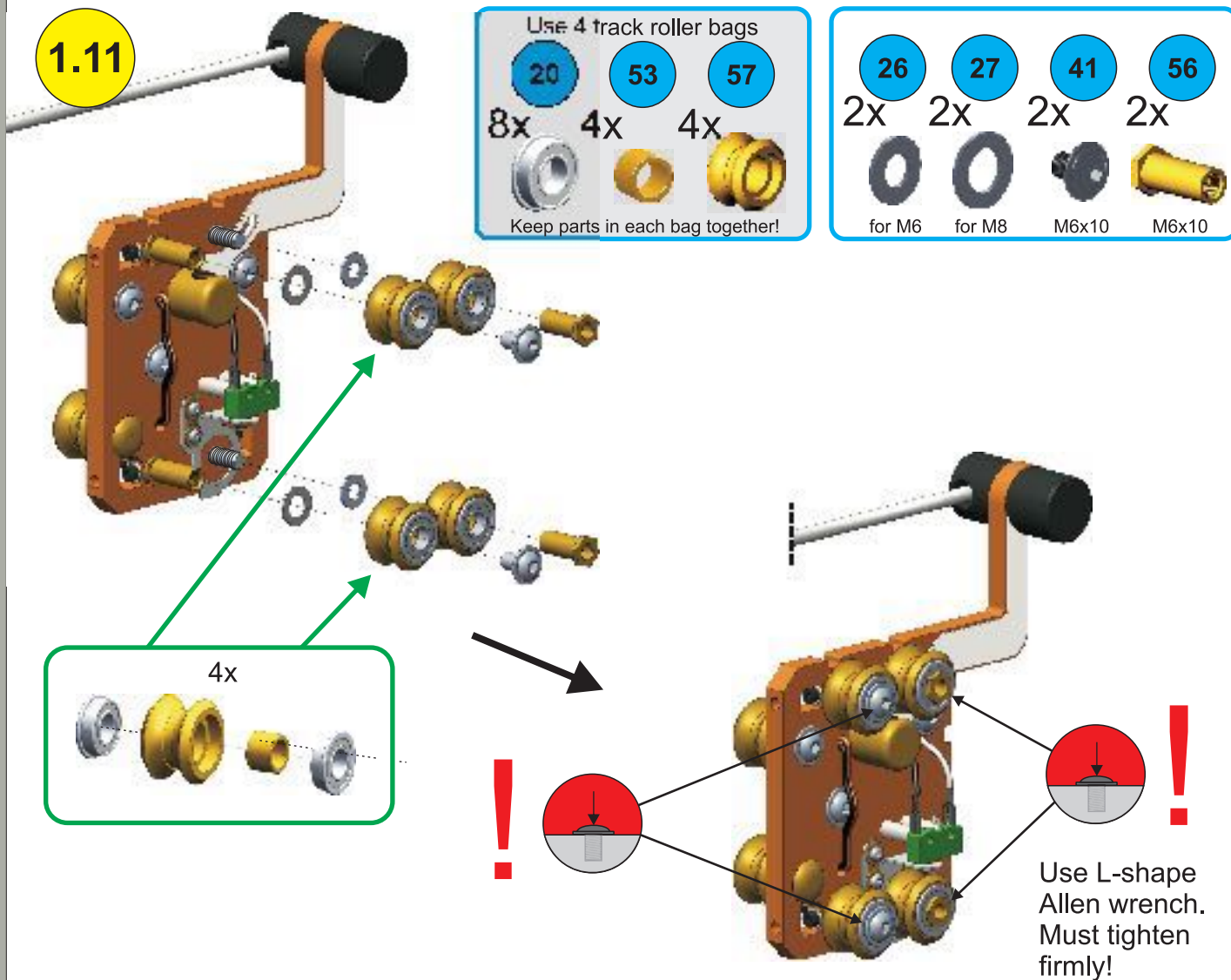
for M3

M3x14

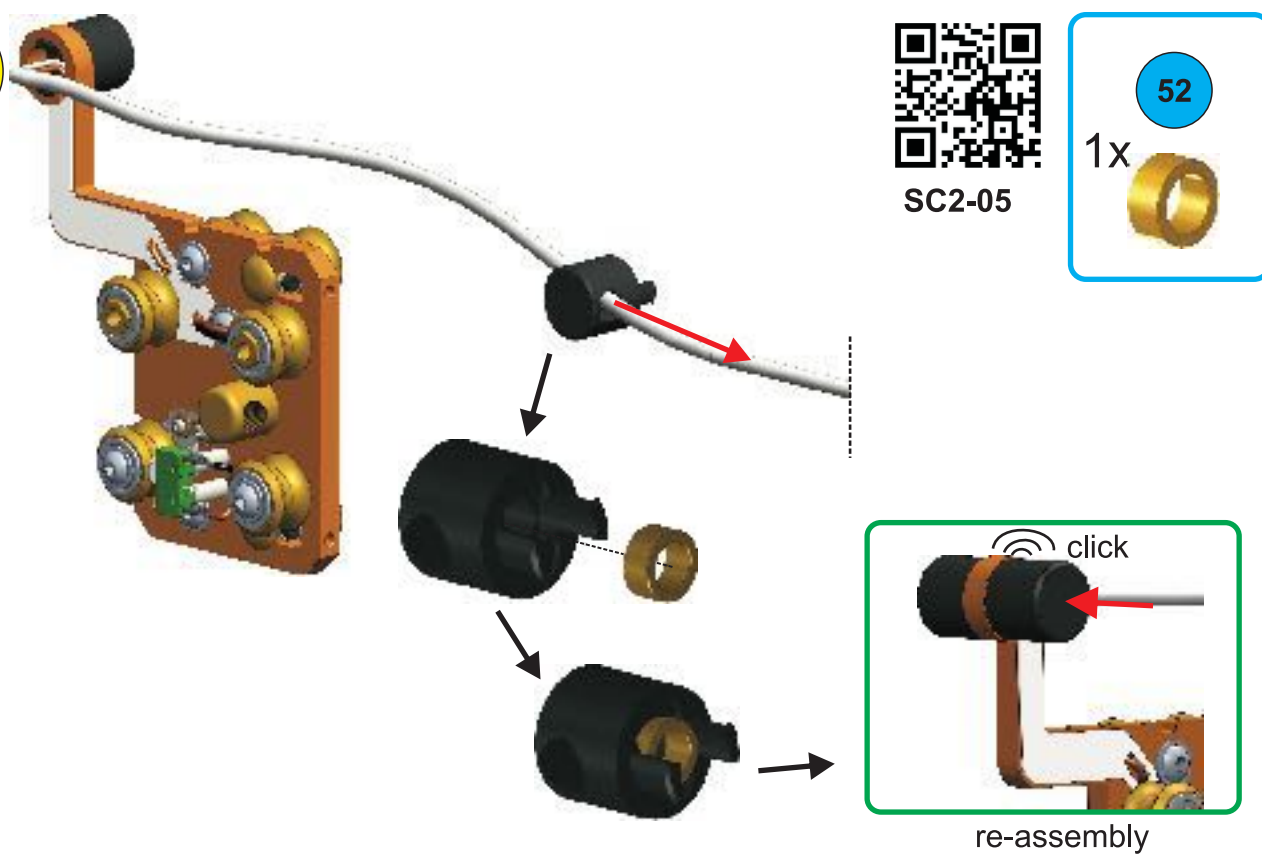
M6x20



1.11



1.12

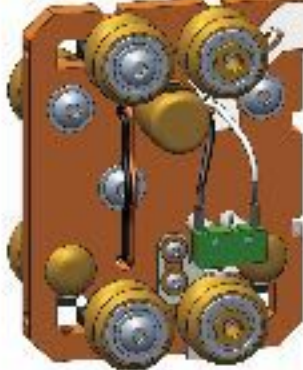




1.13

## Z-lead screw nut alignment

Check lead screw edge for burr and remove



$$x=y$$

1. Lead screw must be parallel to outer edge



SC2-06

16

1x



$$x=y$$

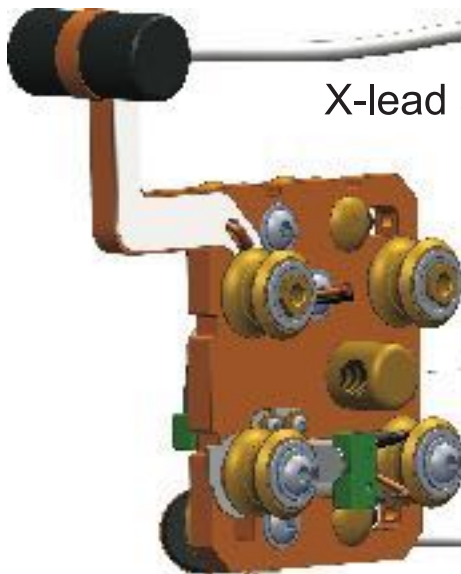
2. Play in lead screw nut must be averaged

Remove lead screw after alignment

1.14

## X-lead screw nut alignment

Check lead screw edge for burr and remove



13

1x



$$x=y$$

1. Lead screw must be parallel to outer edge

x  
y

2. Play in lead screw nut must be averaged

$$x=y$$

Remove lead screw after alignment

## Z-motor

1x

1x

4x

 $2x$ 

1x

1x

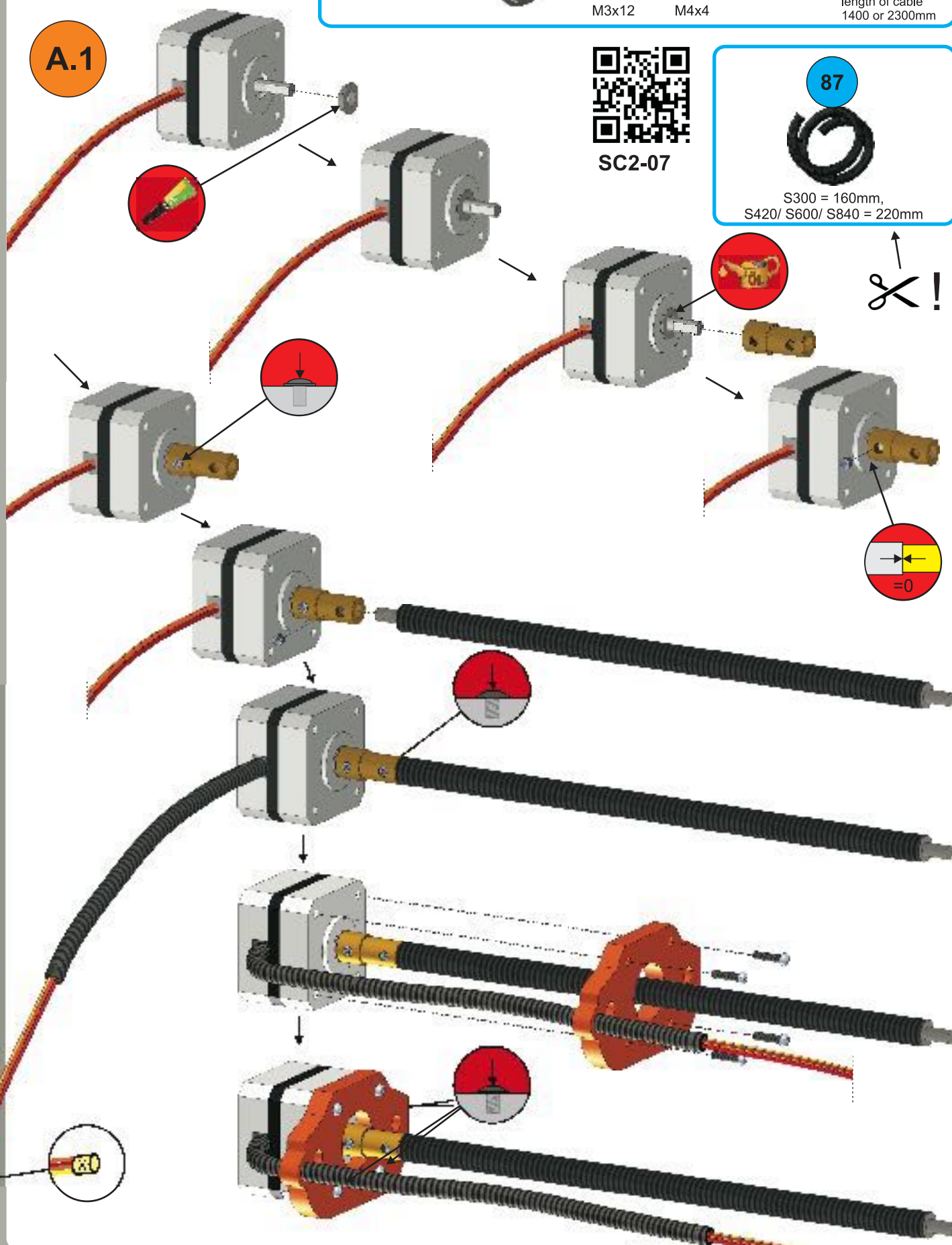
M4x4

length of cable  
1400 or 2300mm



**SC2-07**

S300 = 160mm,  
S420/ S600/ S840 = 220mm



2

## Z-axis



2.1

3

1x



12

1x



39

1x



M6x20

43

3x



M6x25

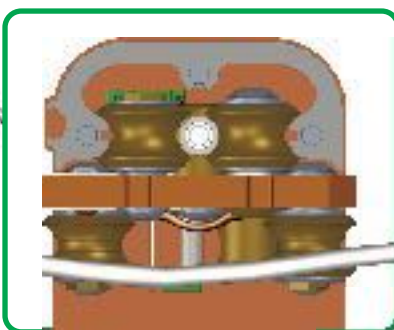
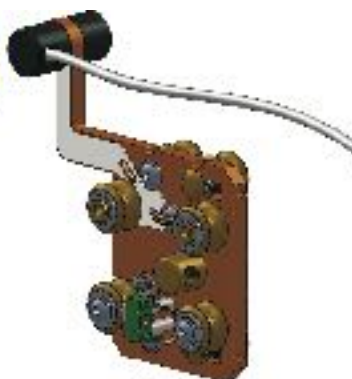


3x

optional spindle adapter

adapter  $\varnothing 43$  mm/  $\varnothing 20$  mm

2.2



21

1x



1

1x



SC2-08

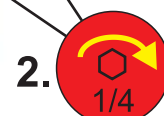
21



1.



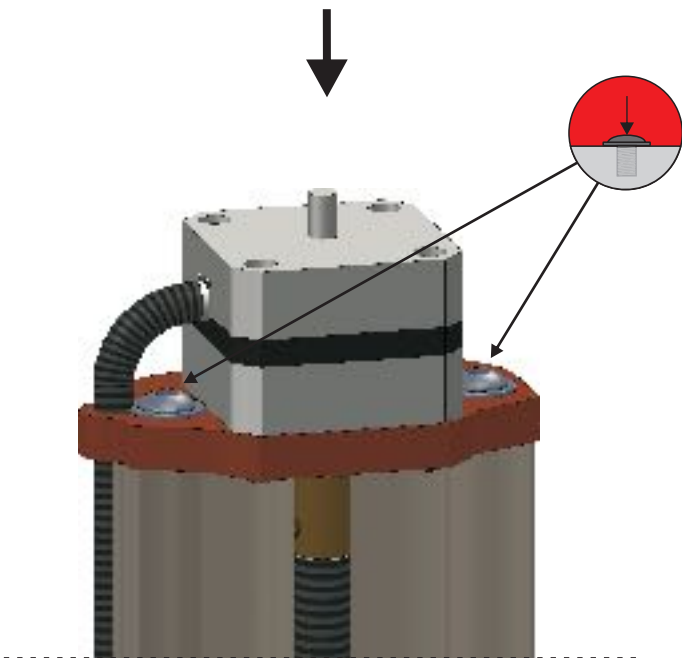
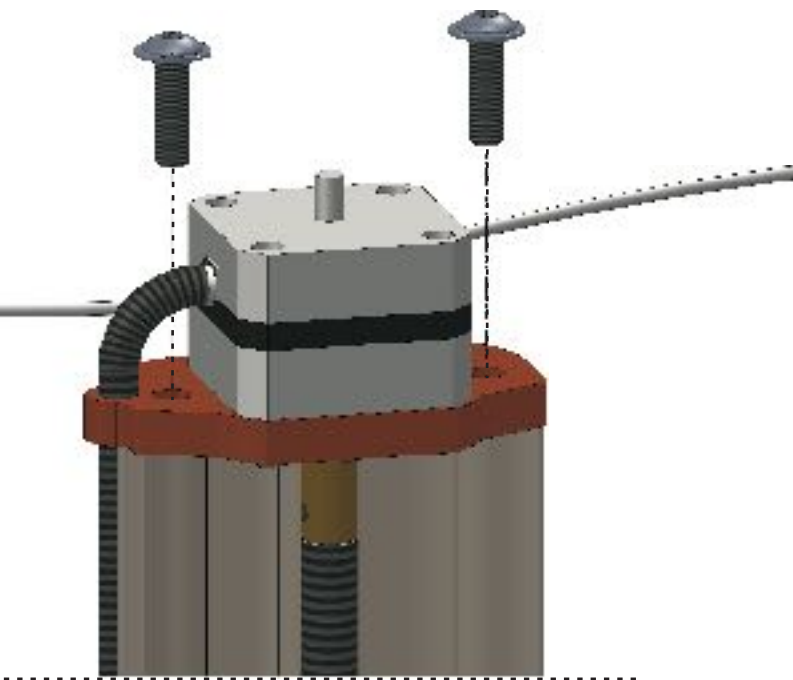
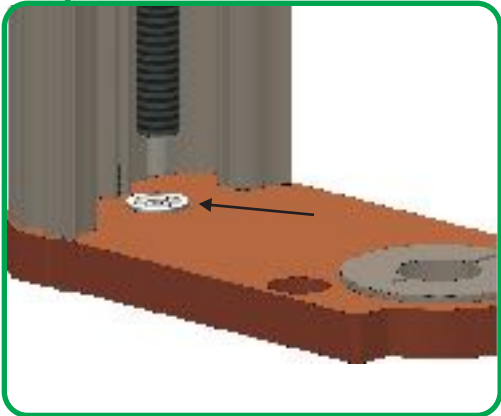
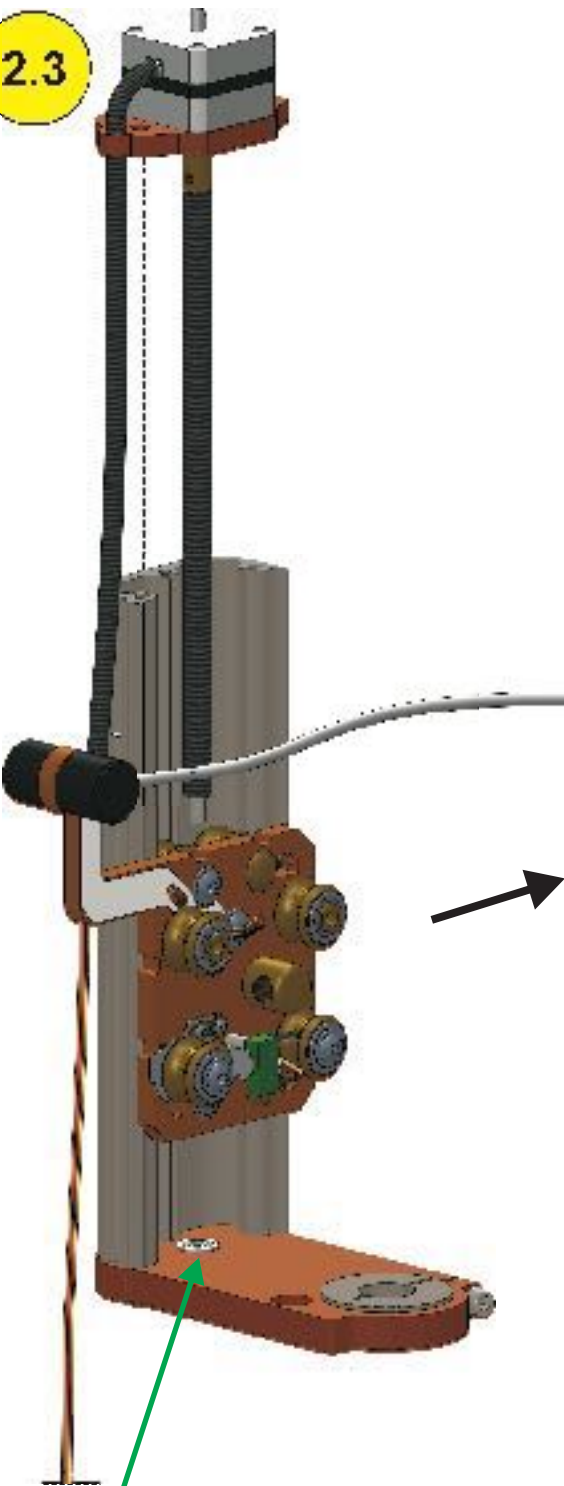
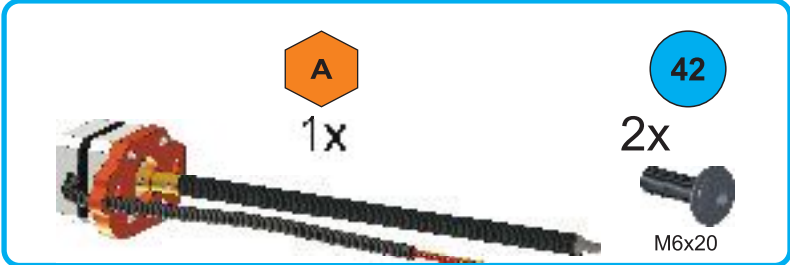
2.



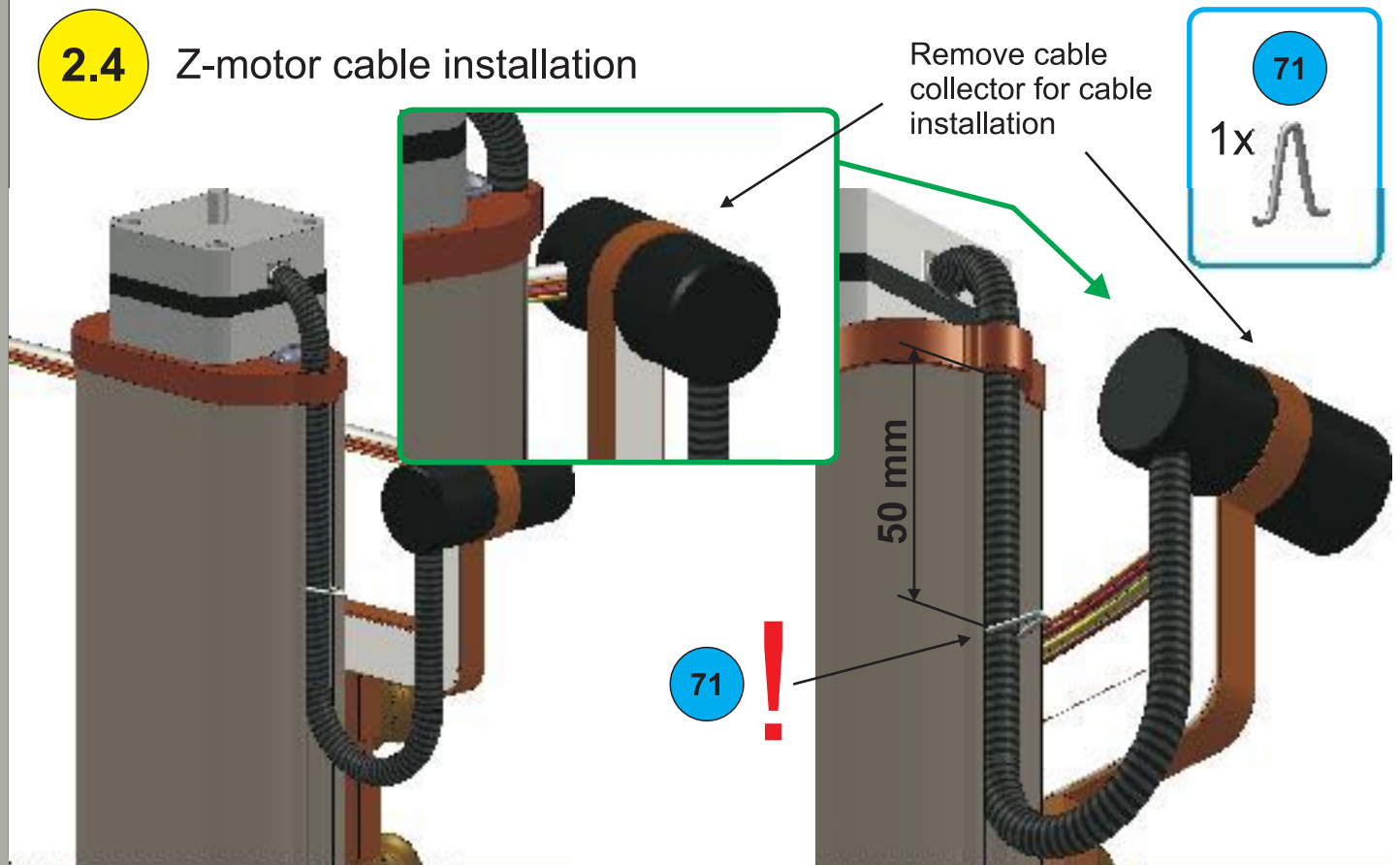
1/4



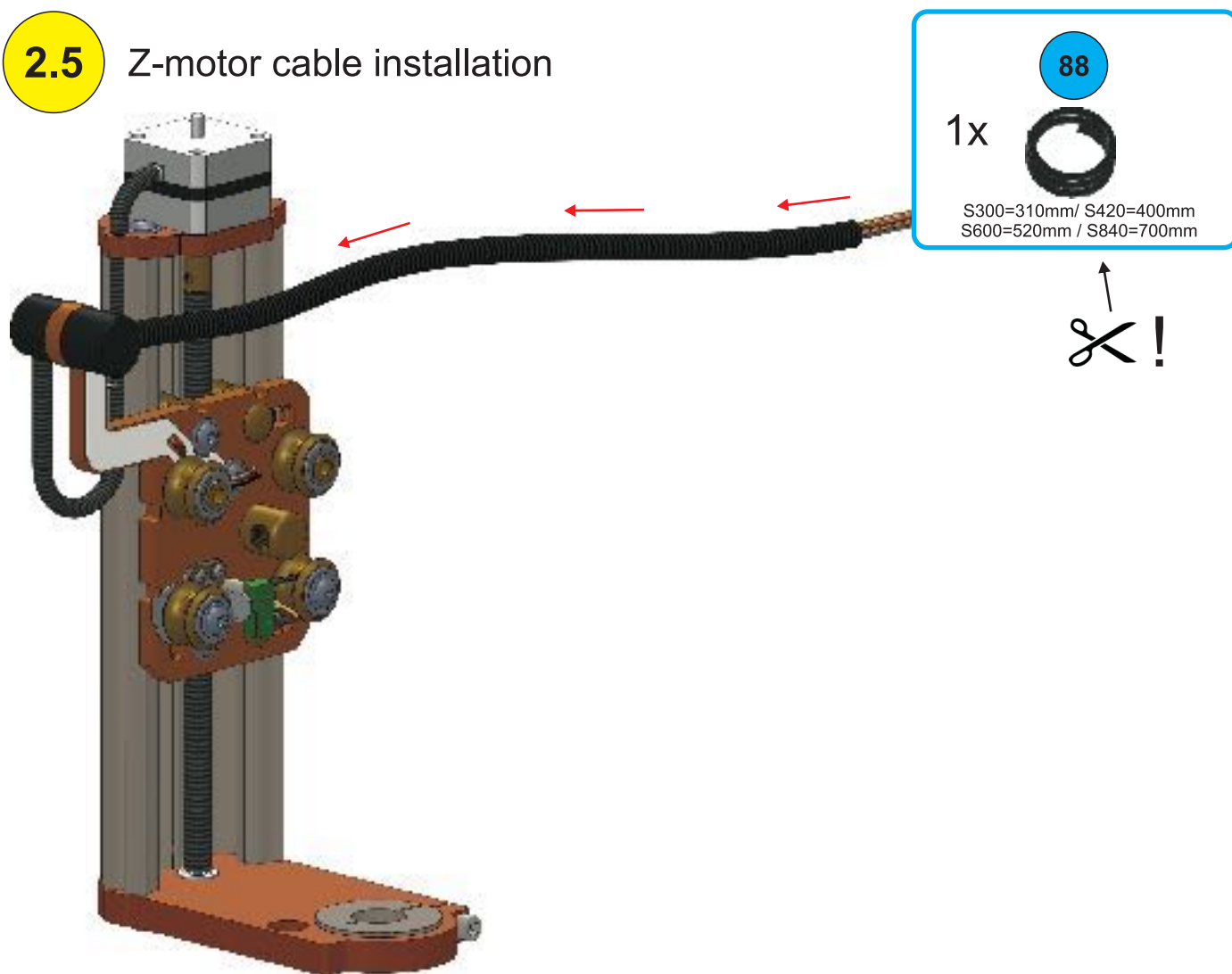
2.3



## 2.4 Z-motor cable installation



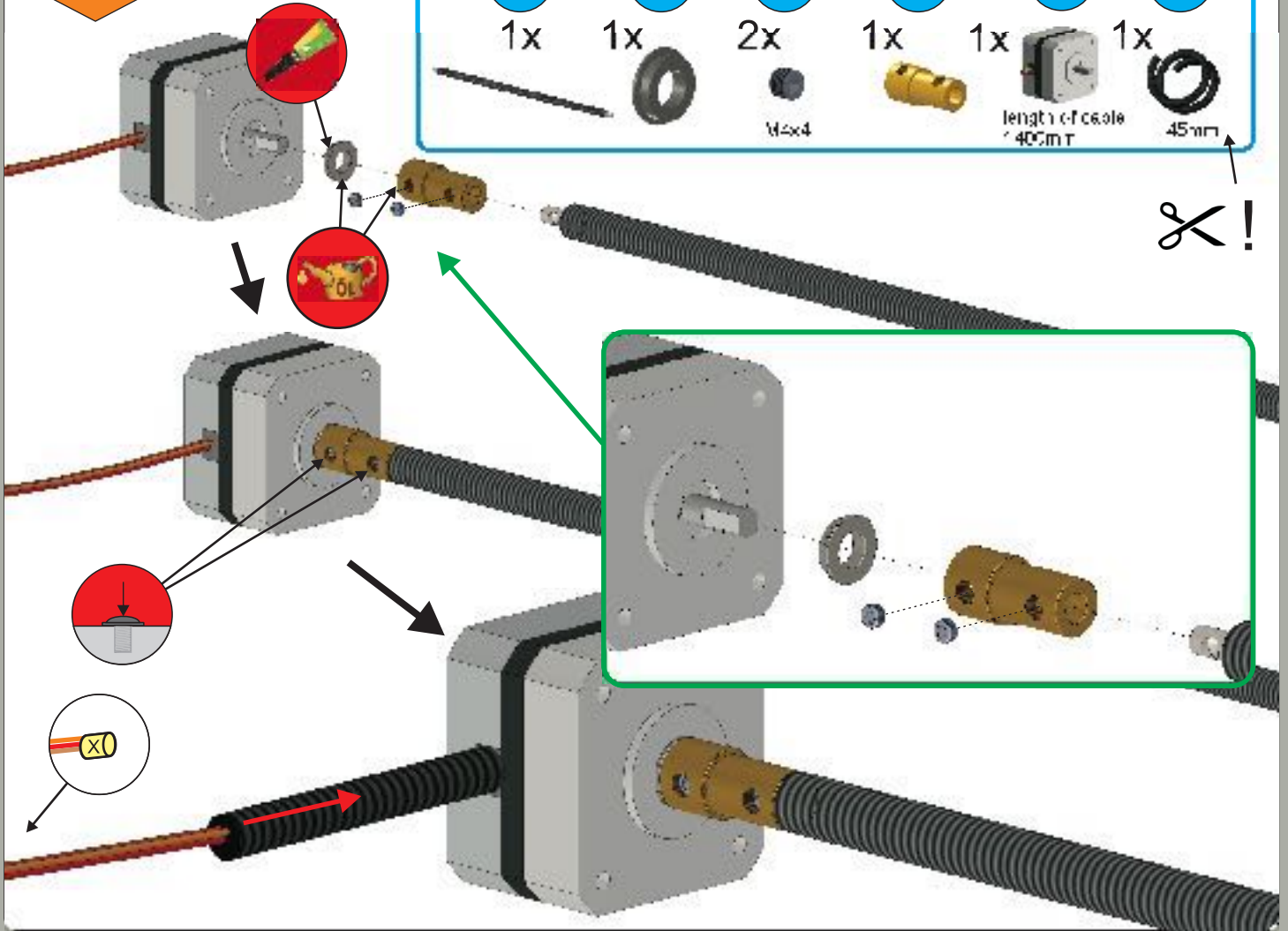
## 2.5 Z-motor cable installation







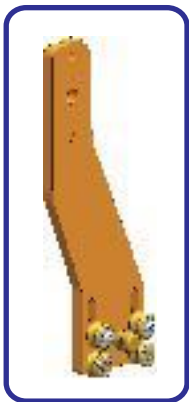
## X-motor



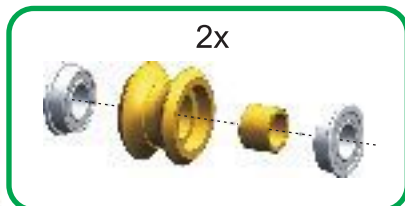
- | 13 | 22 | 45   | 58 | 82                      | 87   |
|----|----|------|----|-------------------------|------|
| 1x | 1x | 2x   | 1x | 1x                      | 1x   |
|    |    | M4x4 |    | length of cable<br>40cm | 45mm |



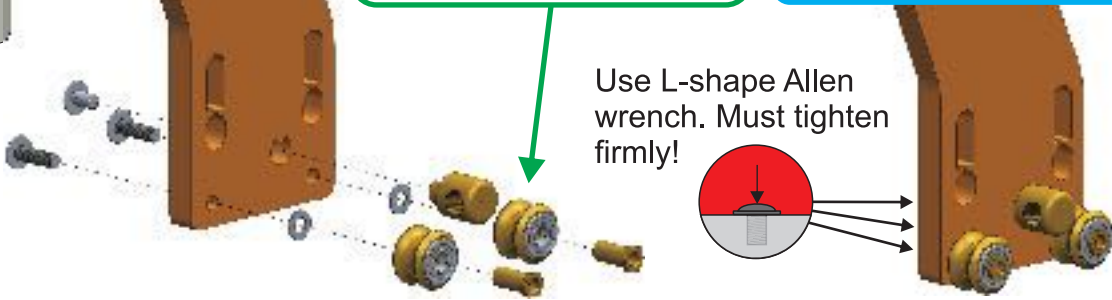
## Gantry upright (right)



- | 1  | 26     | 41    | 43    | 56    | 59 |
|----|--------|-------|-------|-------|----|
| 1x | 2x     | 1x    | 2x    | 2x    | 1x |
|    | for M6 | M6x10 | M6x25 | M6x10 |    |



- Use 2 track roller bags
- | 20                               | 53 | 57 |
|----------------------------------|----|----|
| 4x                               | 2x | 2x |
|                                  |    |    |
| Keep parts in each bag together! |    |    |

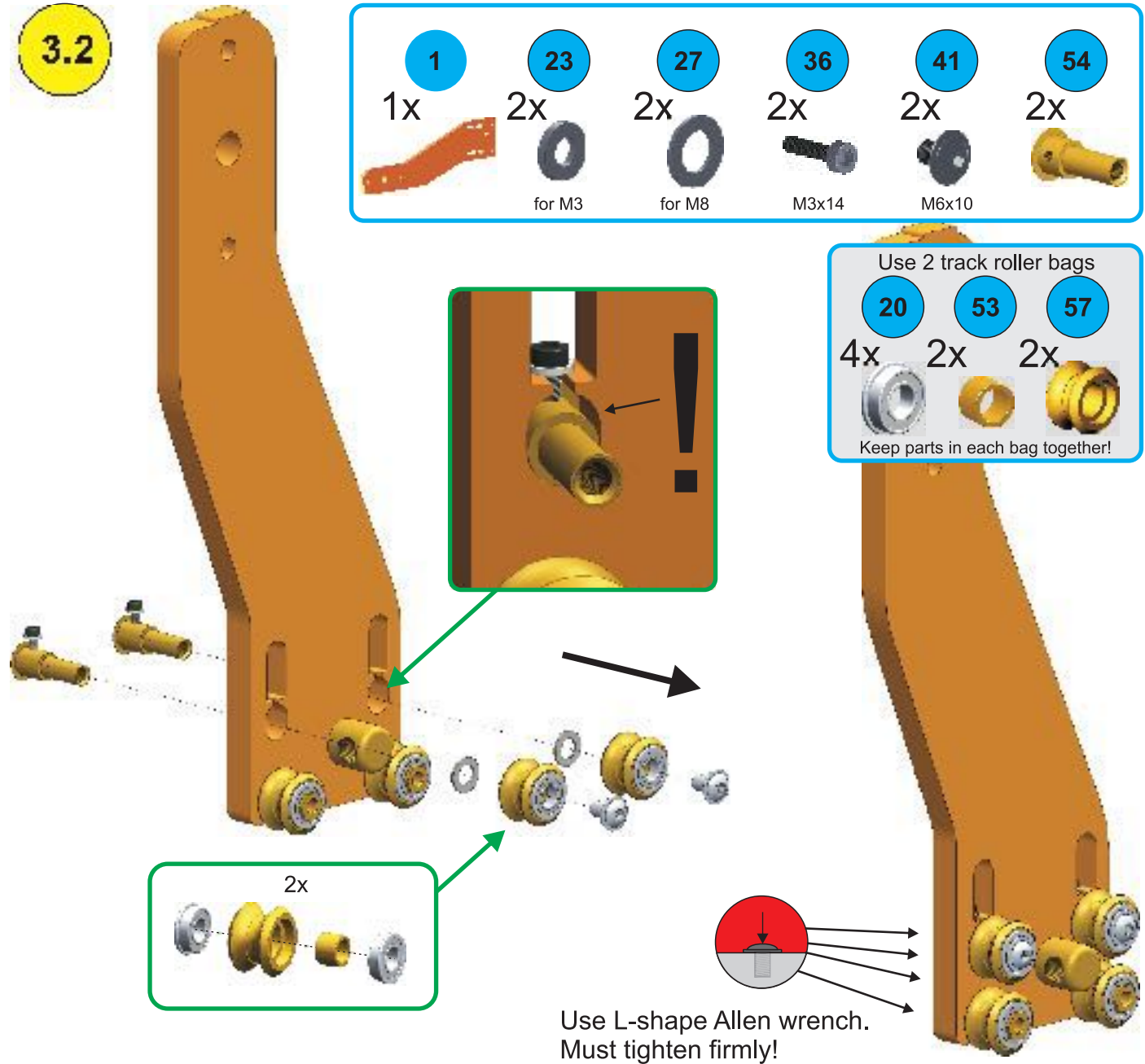


Use L-shape Allen wrench. Must tighten firmly!

3.2

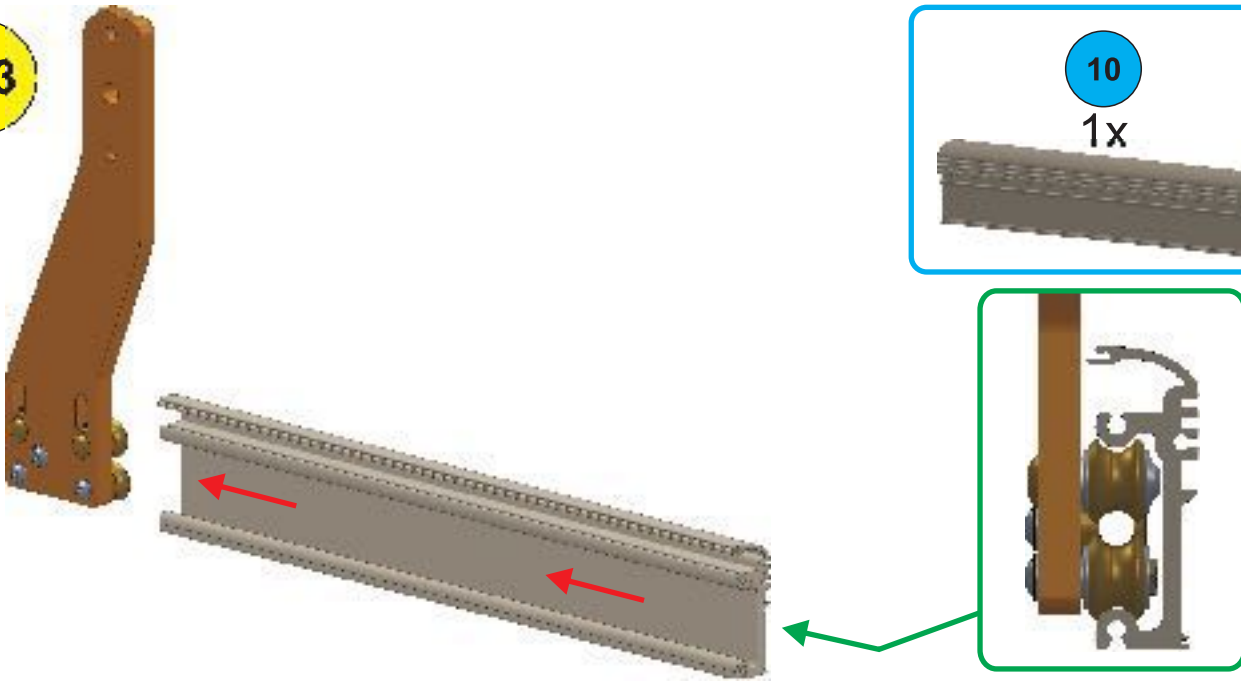
- |    |        |        |       |       |    |
|----|--------|--------|-------|-------|----|
| 1  | 23     | 27     | 36    | 41    | 54 |
| 1x | 2x     | 2x     | 2x    | 2x    | 2x |
|    |        |        |       |       |    |
|    | for M3 | for M8 | M3x14 | M6x10 |    |

- Use 2 track roller bags
- |                                  |    |    |
|----------------------------------|----|----|
| 20                               | 53 | 57 |
| 4x                               | 2x | 2x |
|                                  |    |    |
| Keep parts in each bag together! |    |    |



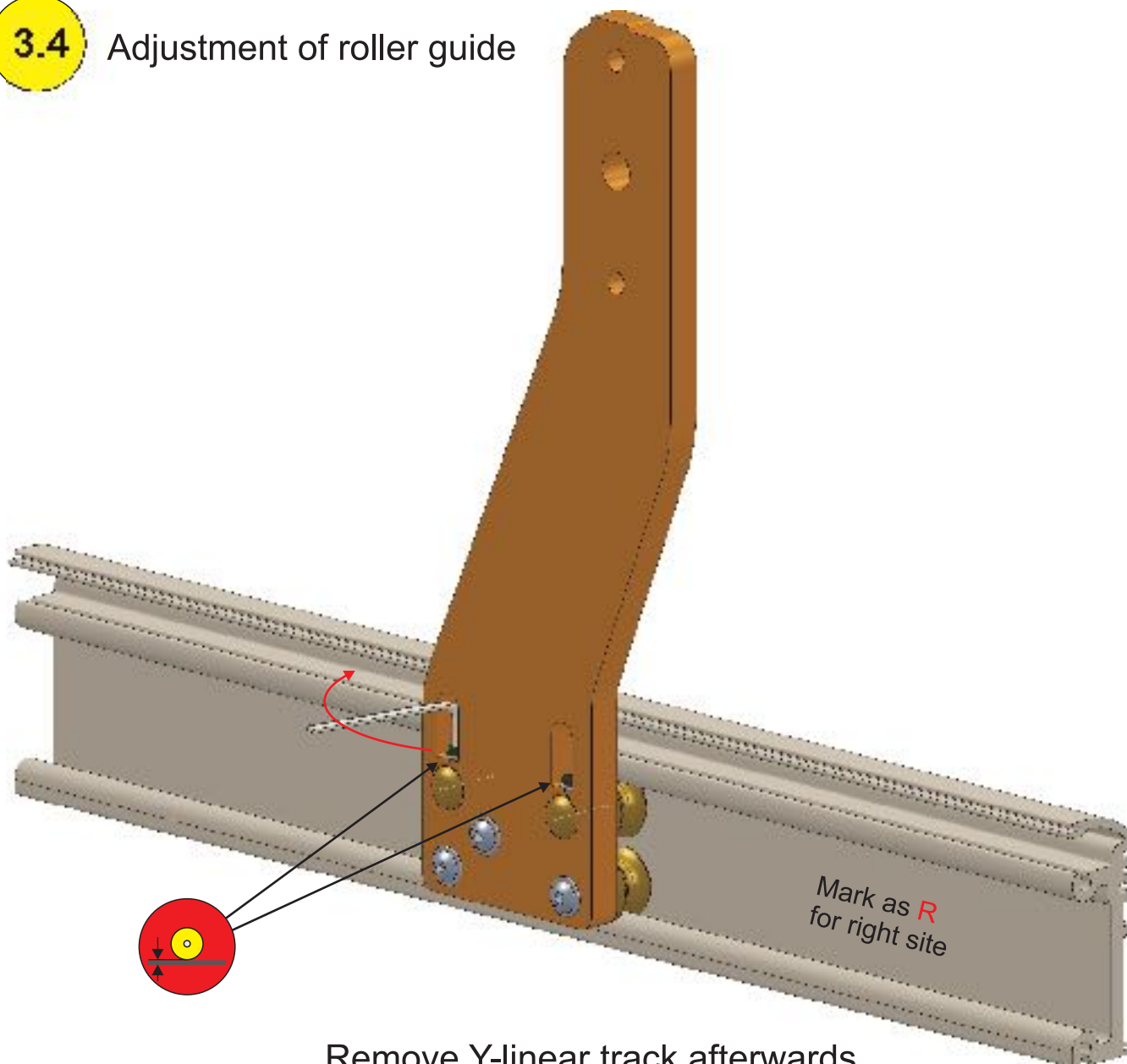
3.3

- |    |
|----|
| 10 |
| 1x |
|    |



### 3.4

## Adjustment of roller guide

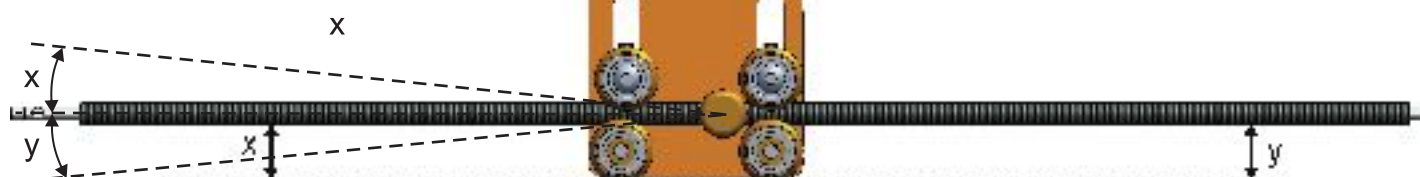
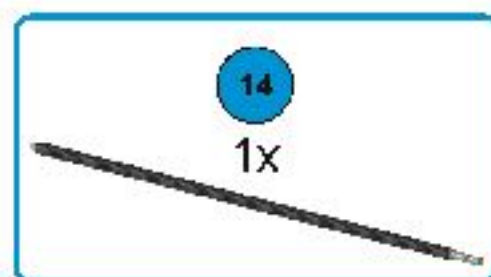


Remove Y-linear track afterwards

### 3.5

## Y-lead screw nut alignment

Check lead screw edge for burr and remove



$$x=y$$

1. Lead screw must be parallel to outer edge

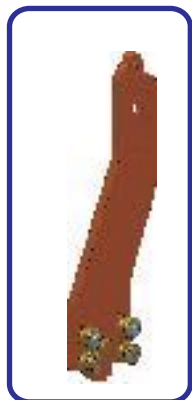
2. Play in lead screw nut must be averaged

$$x=y$$

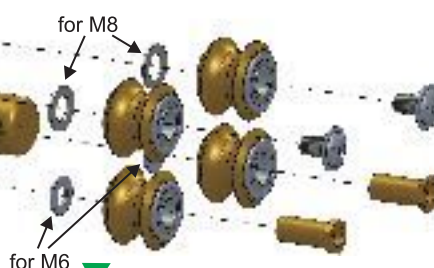
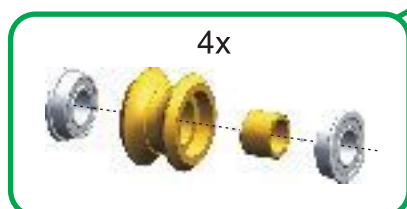
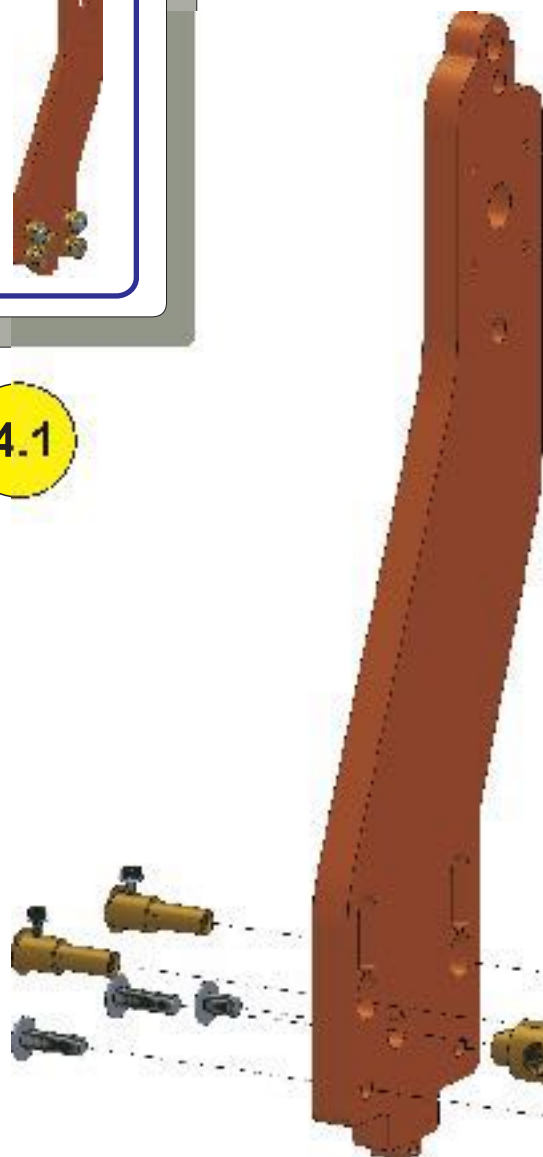
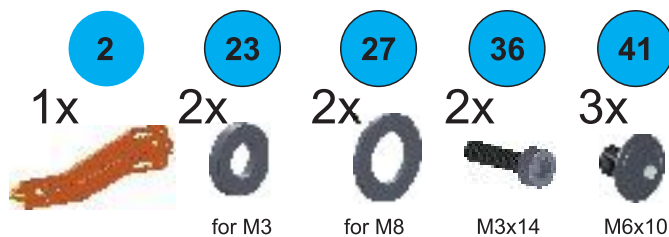
Remove lead screw after alignment

4

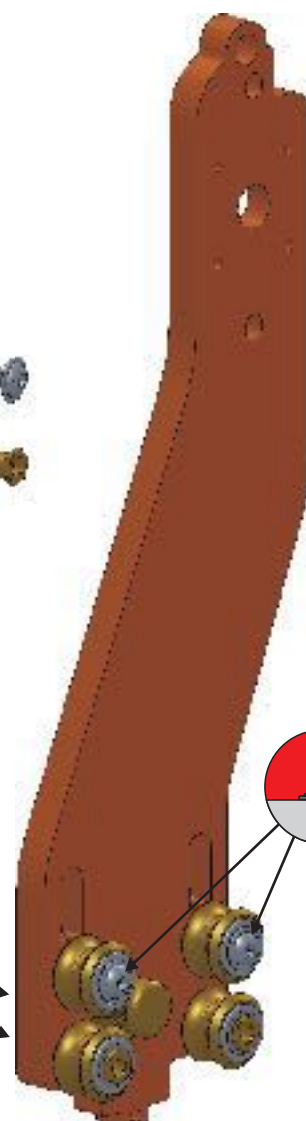
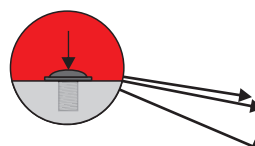
# Gantry upright (left)



4.1

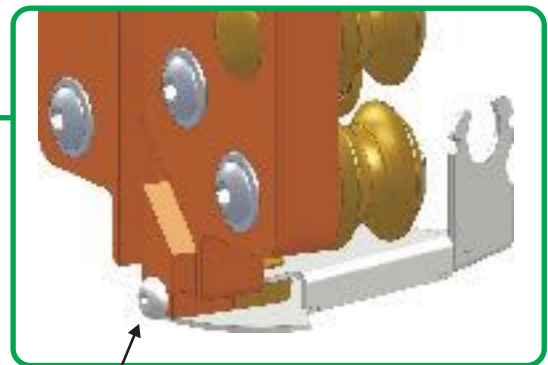
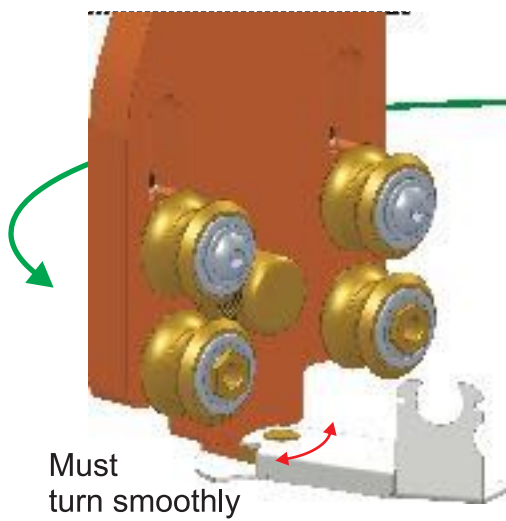
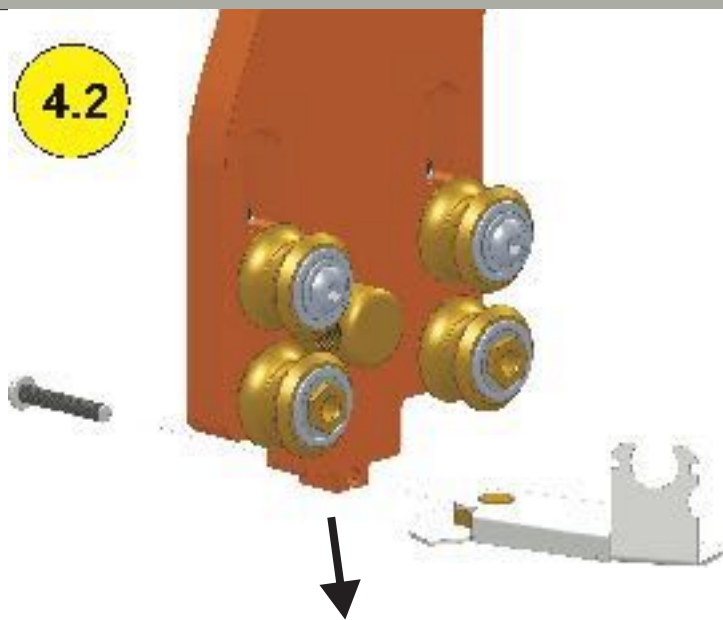
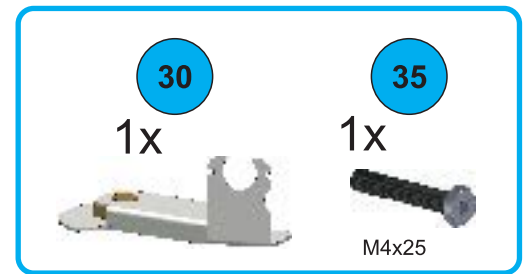


Use L-shape Allen wrench. Must tighten firmly!

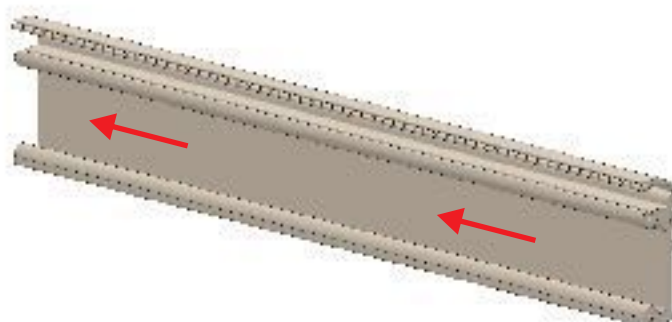
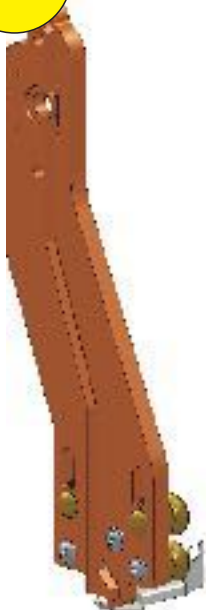
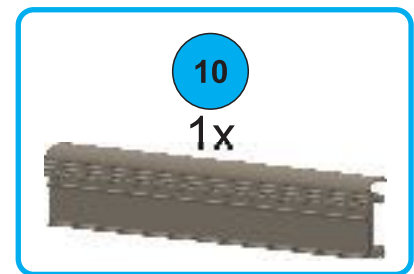




4.2



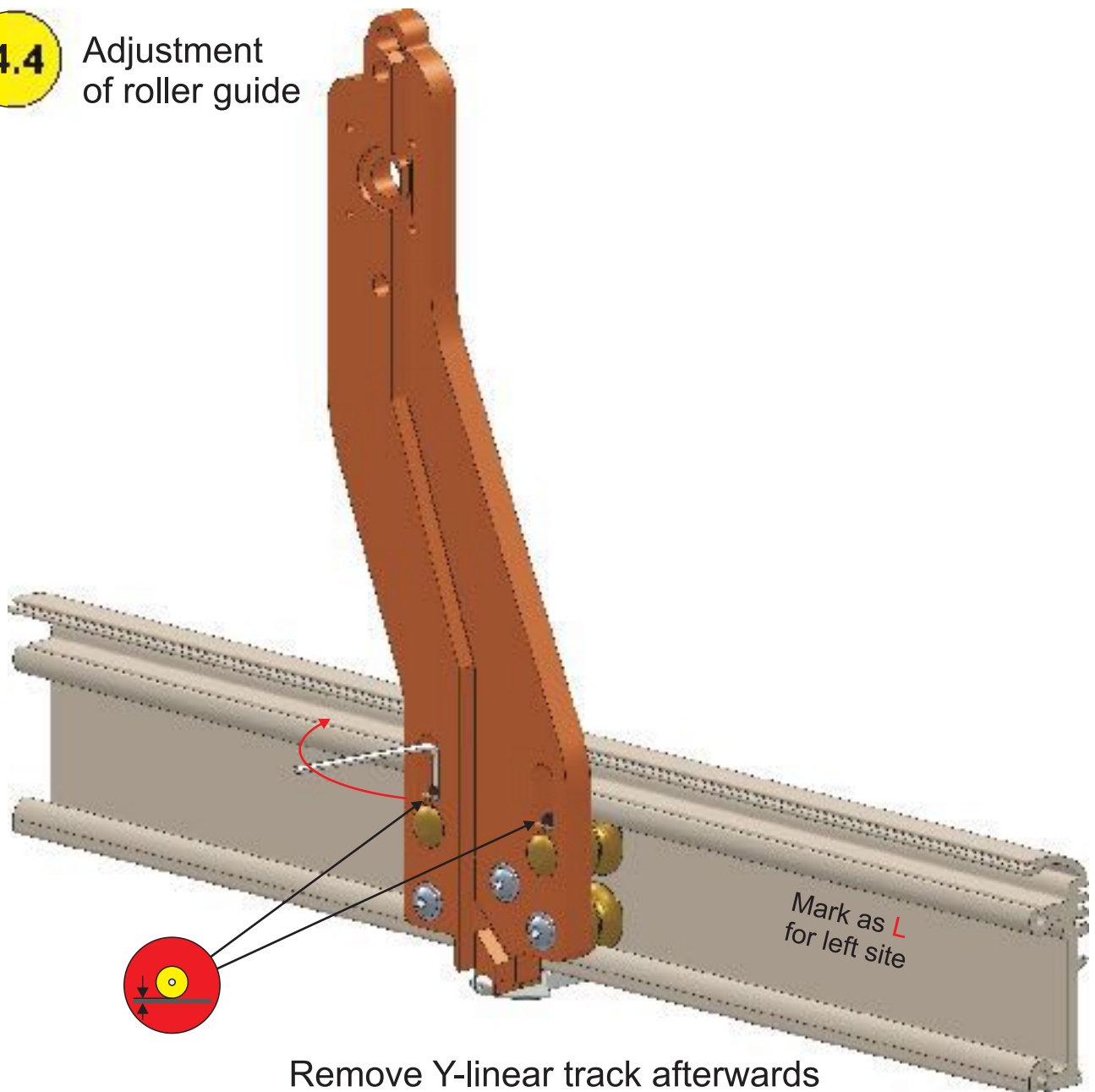
4.3





4.4

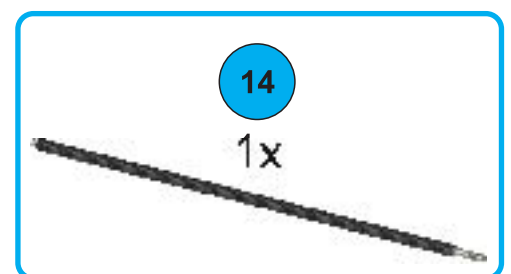
## Adjustment of roller guide



4.5

## Y-lead screw nut alignment

Check lead screw edge for burr and remove

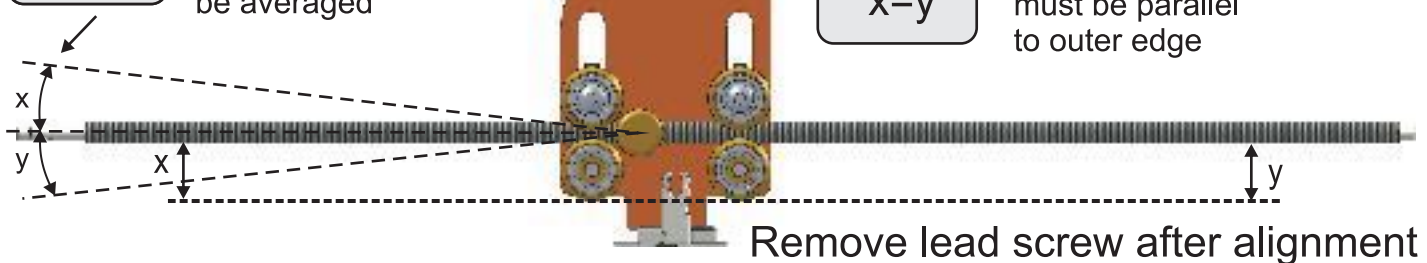


$x=y$

2. Play in lead screw nut must be averaged

$x=y$

1. Lead screw must be parallel to outer edge

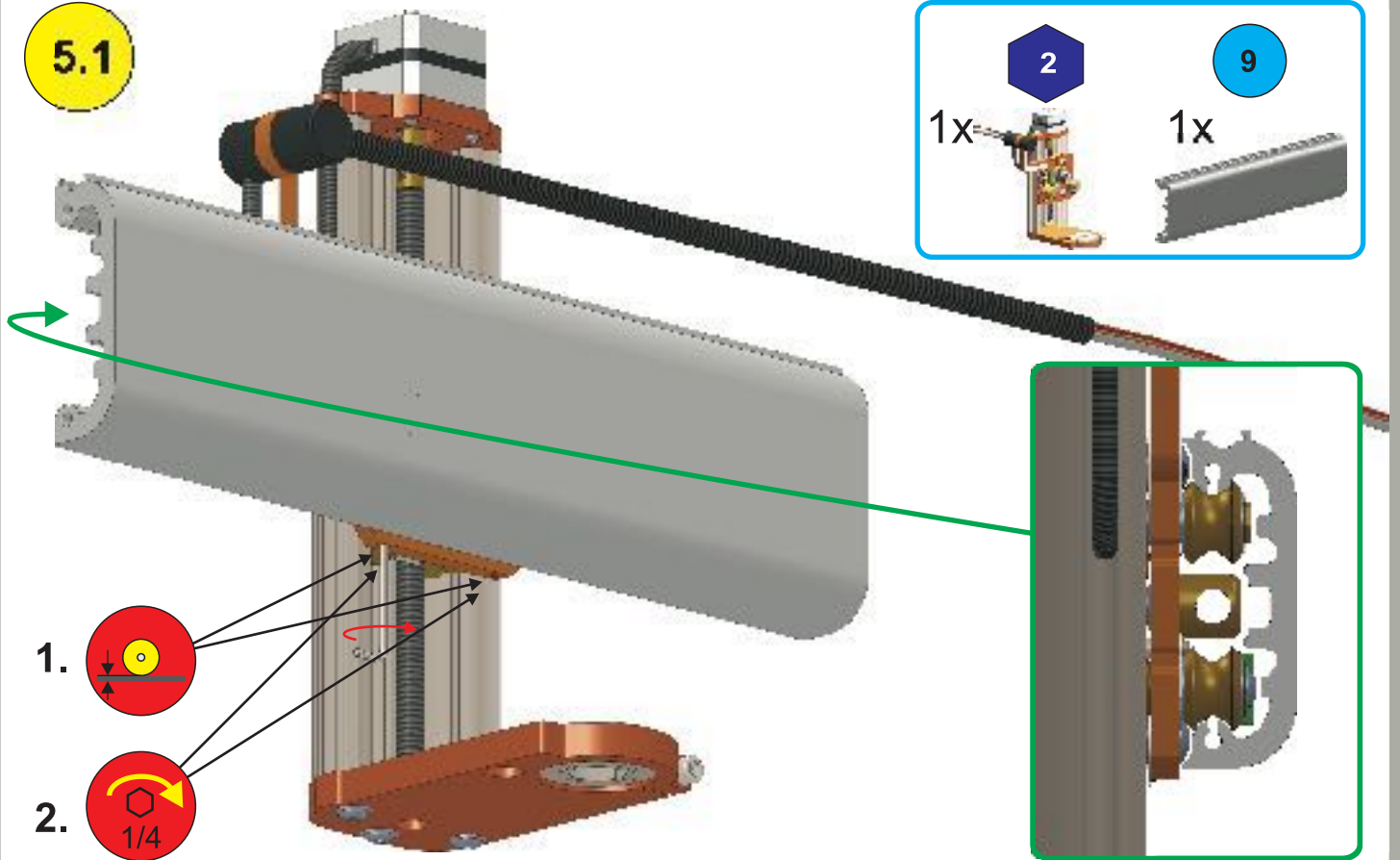


5

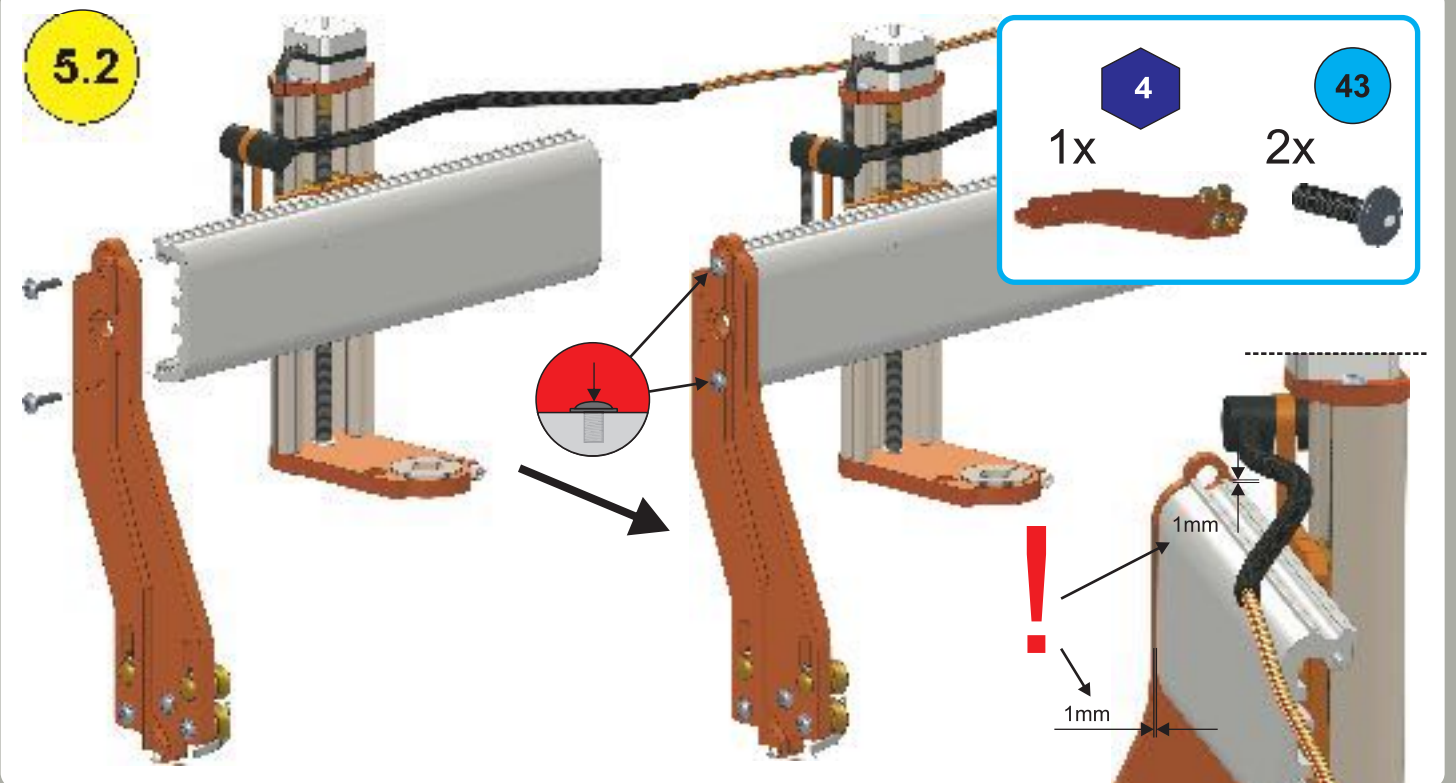


# Gantry assembly

5.1

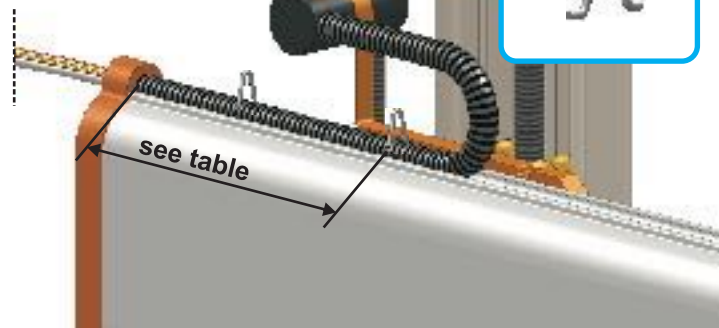
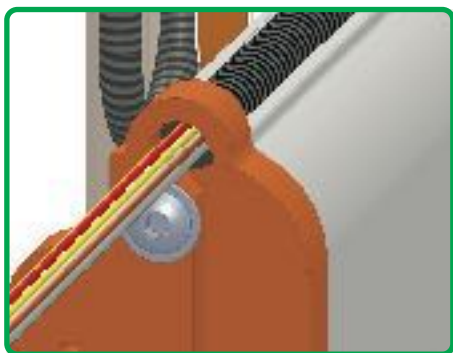


5.2



5.3

## X-motor cable installation



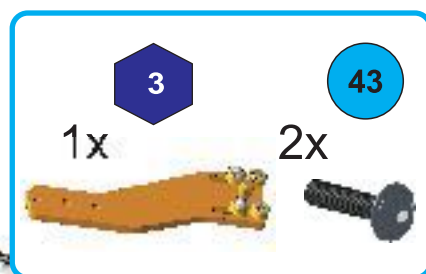
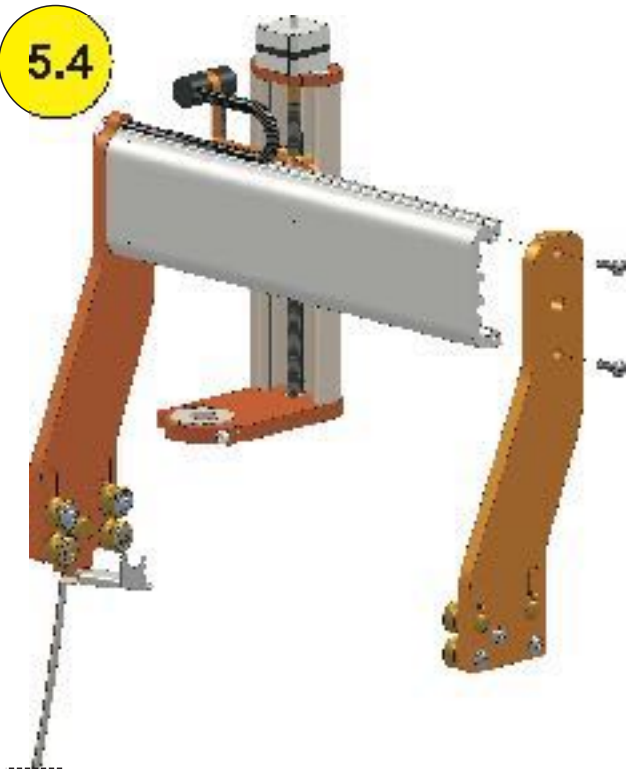
71

2x

see table

Type	Distance
S300	120mm
S420	155mm
S600	205mm
S840	280mm

5.4

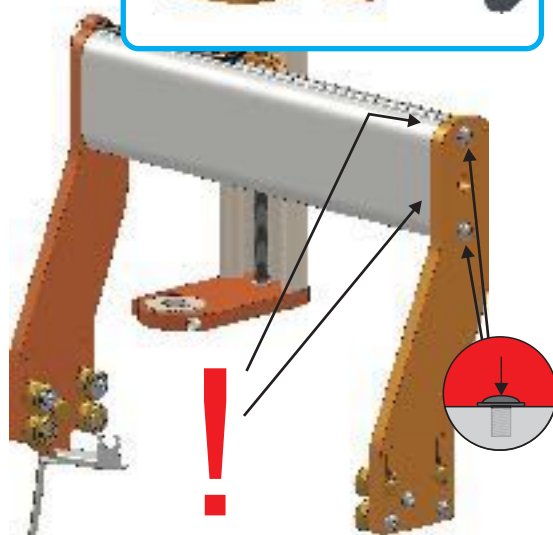


3

1x

43

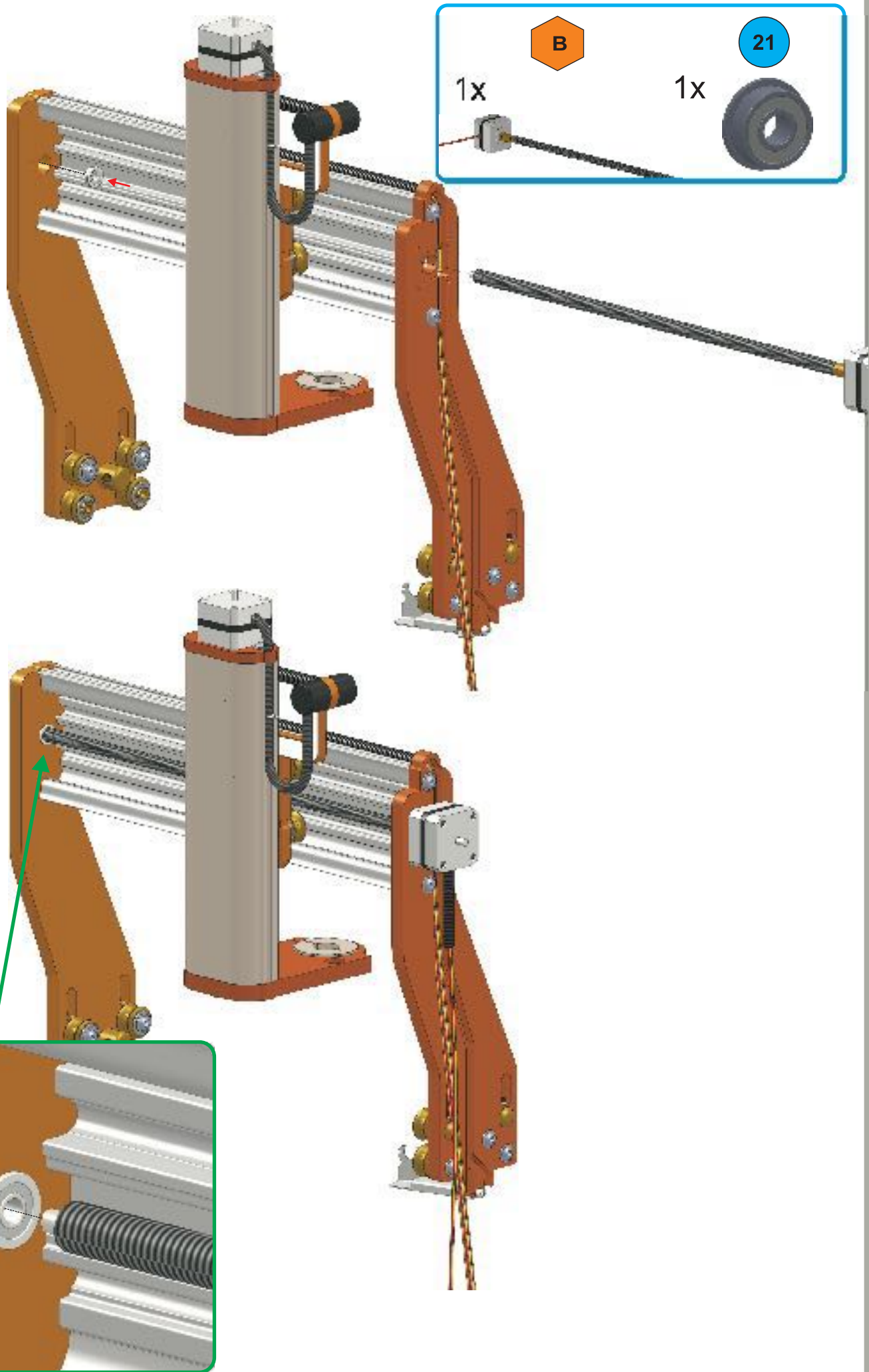
2x



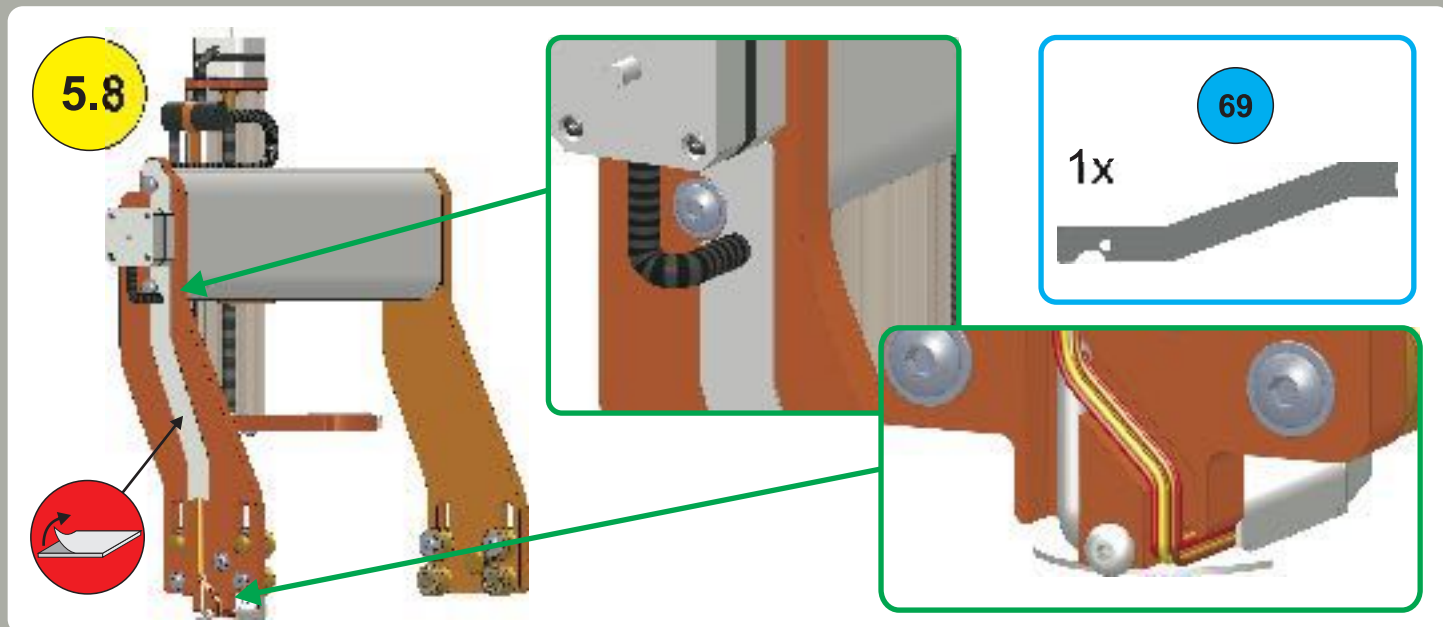
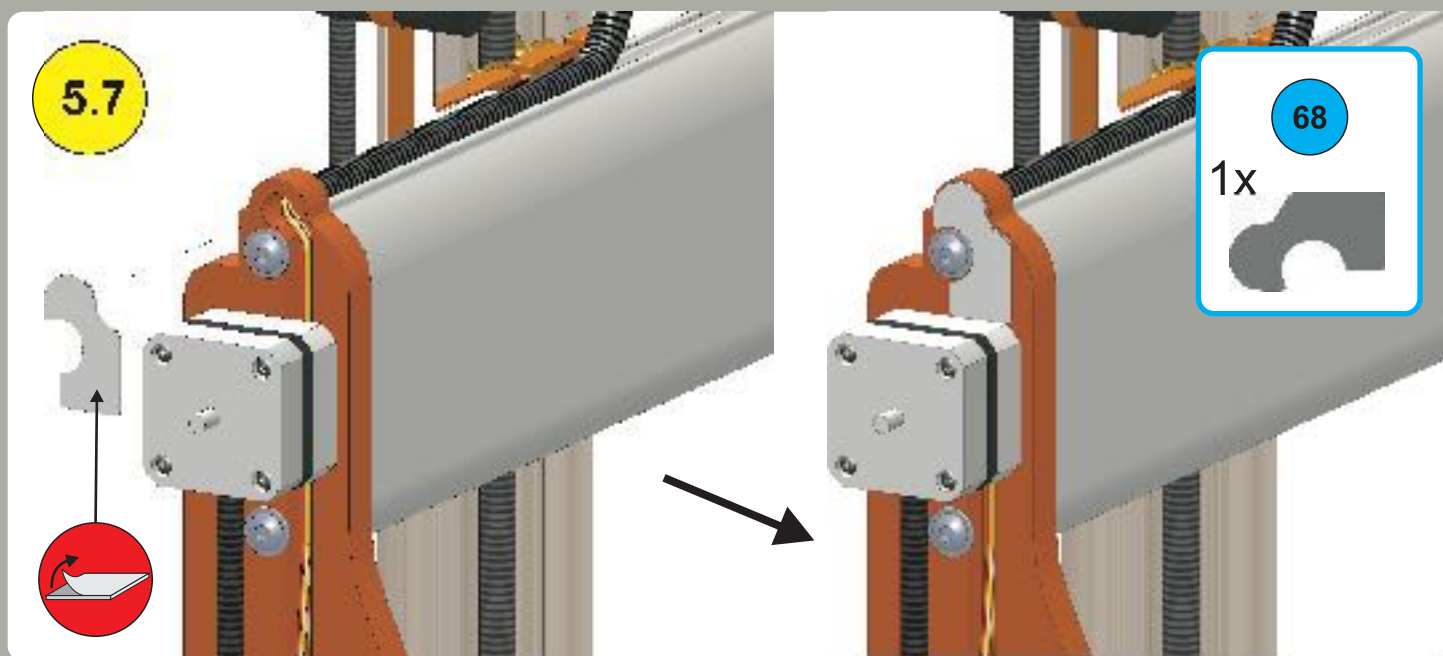
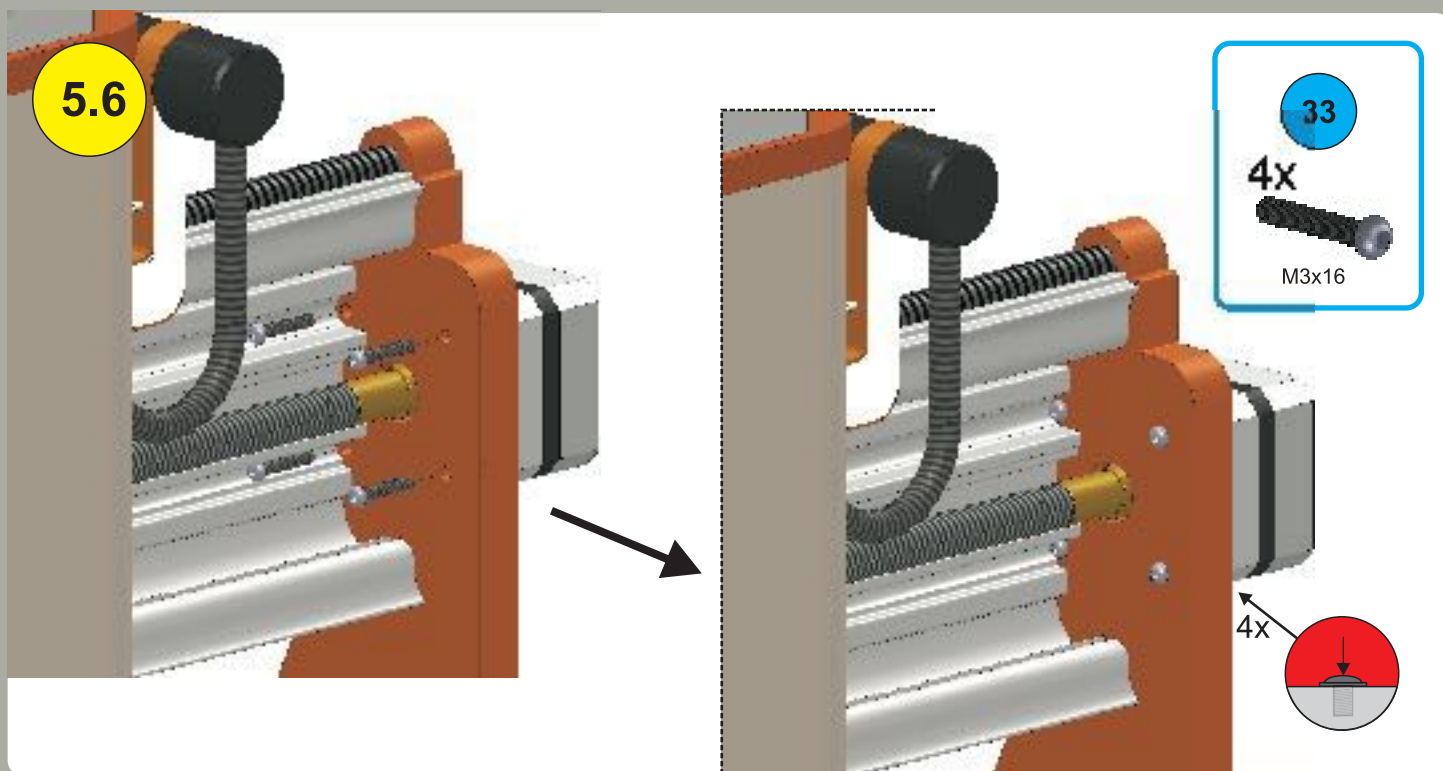
1mm distance  
like step 5.2



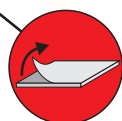
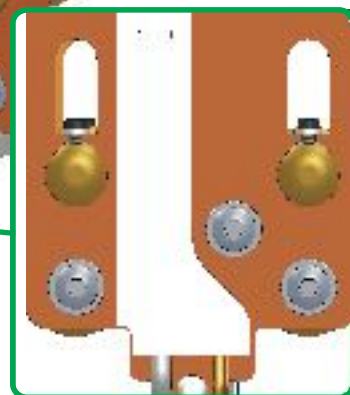
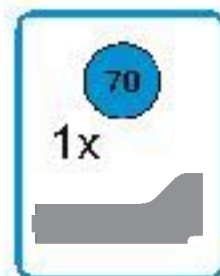
5.5



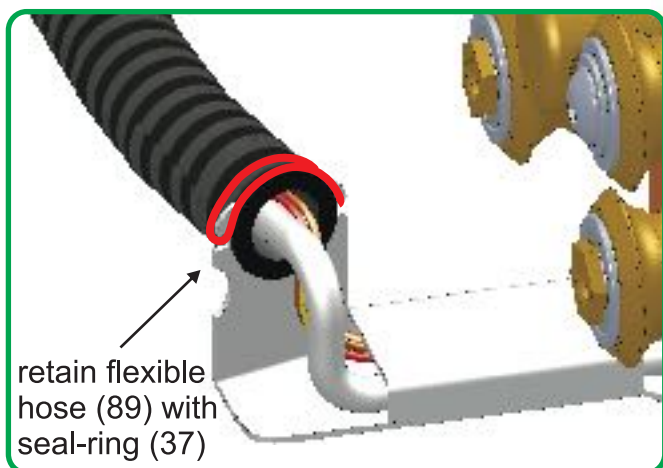
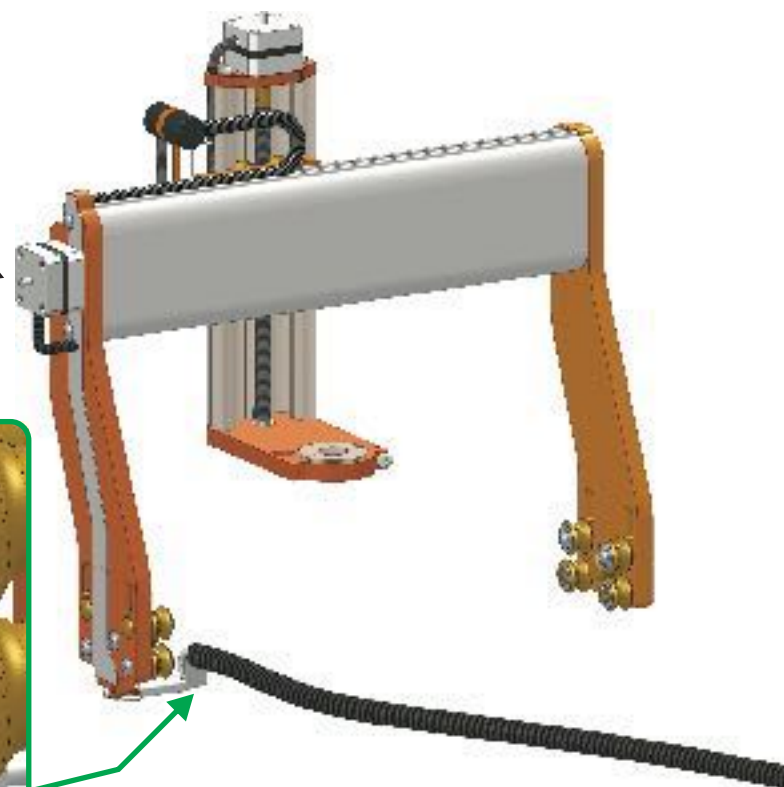
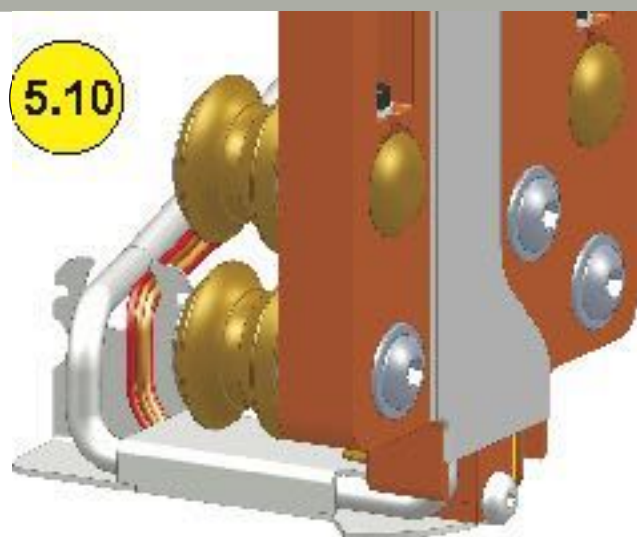
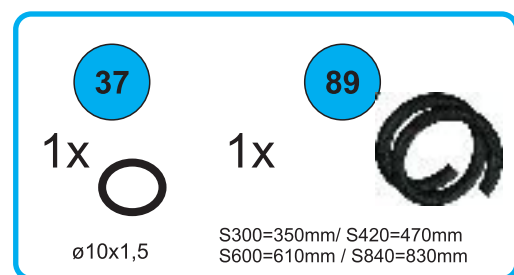




5.9

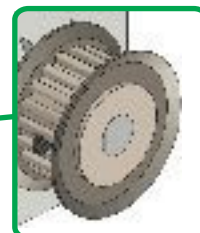
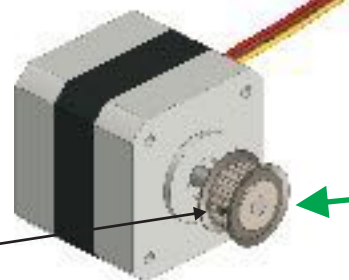
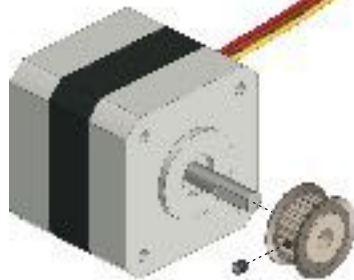


5.10

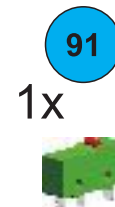
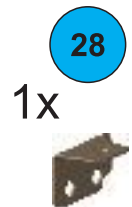
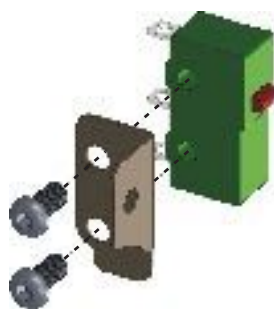




## Motor Y-axis



## End switch Y-axis



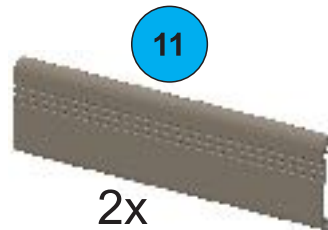
## Cover Y-axis



2x



2x



SC2-09

Don't stretch before cutting!



2x

17

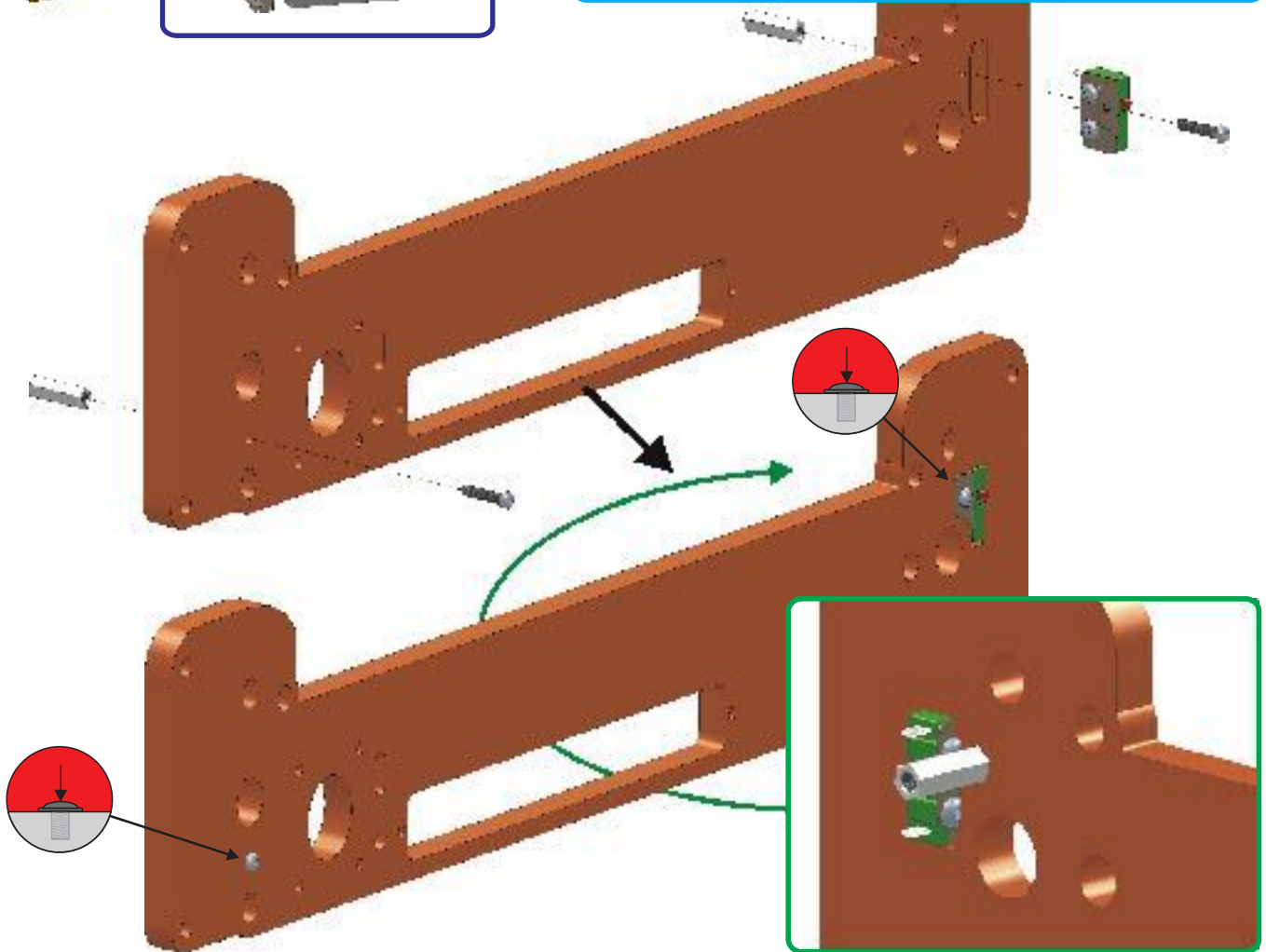
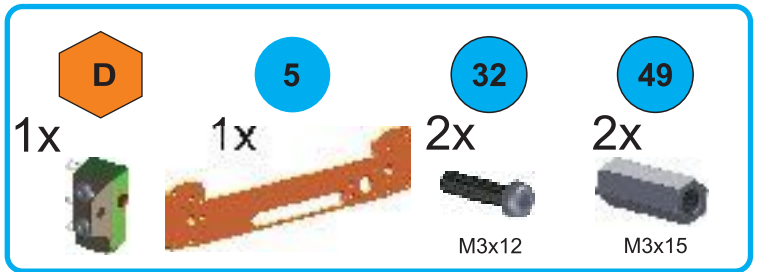
S300= 2x 380mm / S420= 2x 500mm  
S600= 2x 680mm / S840= 2x 920mm



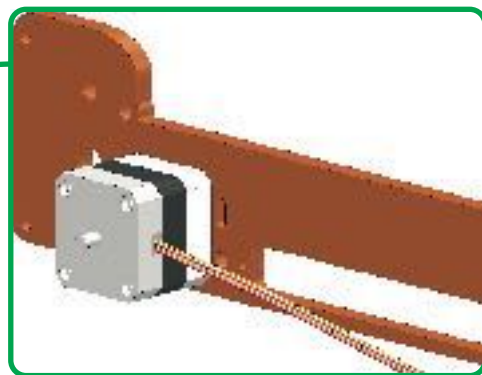
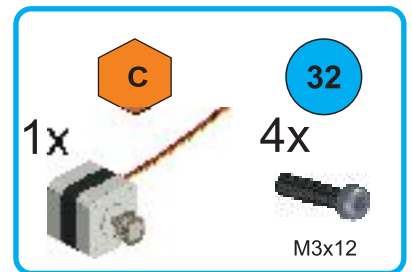
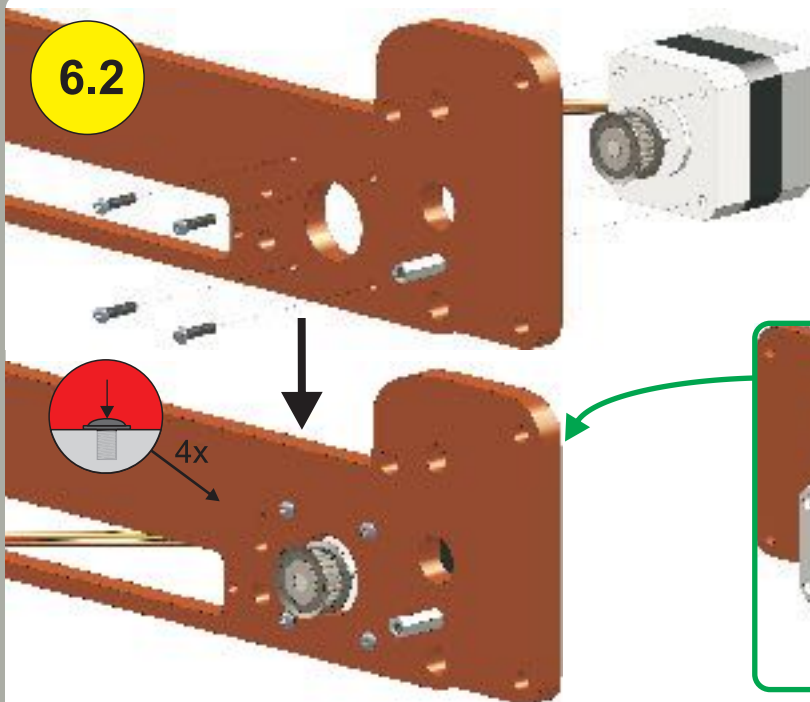


## Base frame

6.1

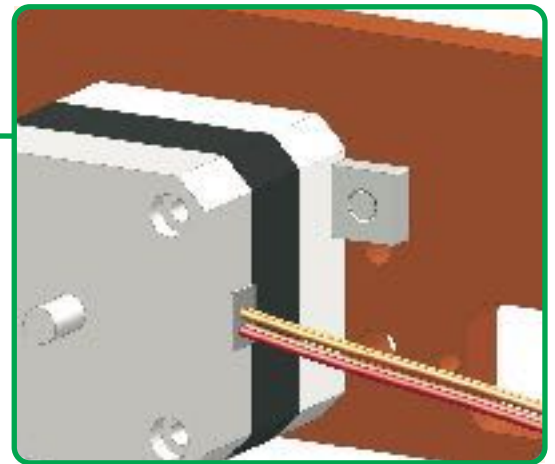
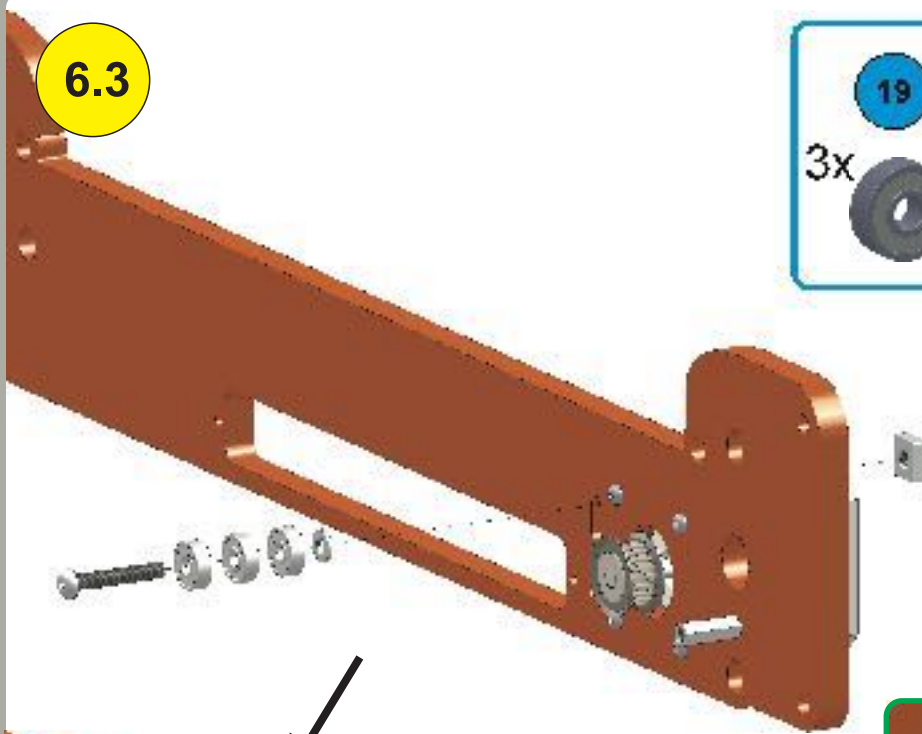
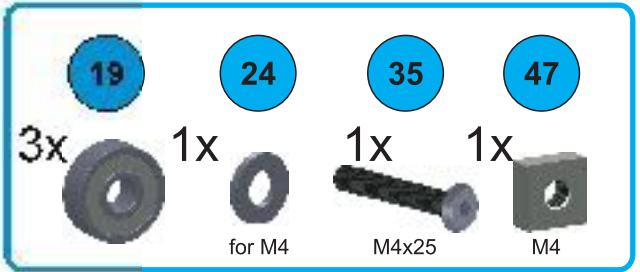


6.2

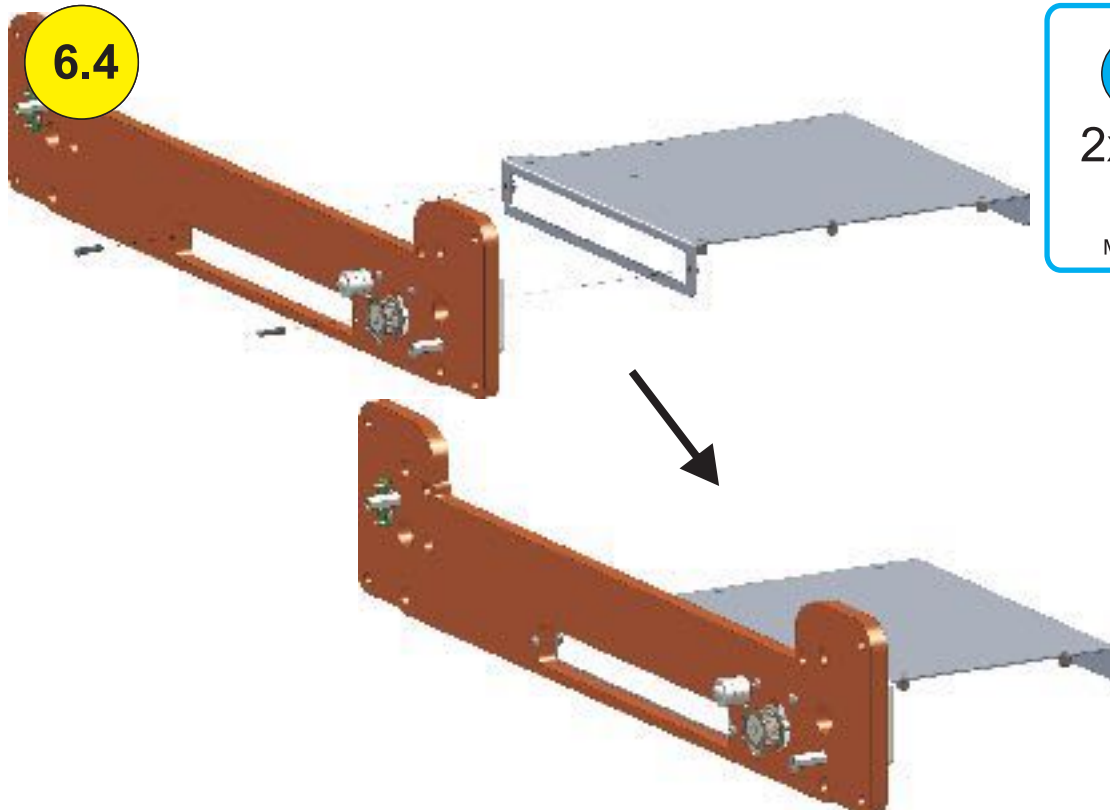
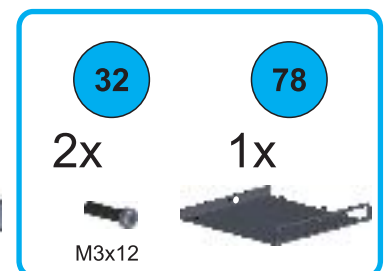




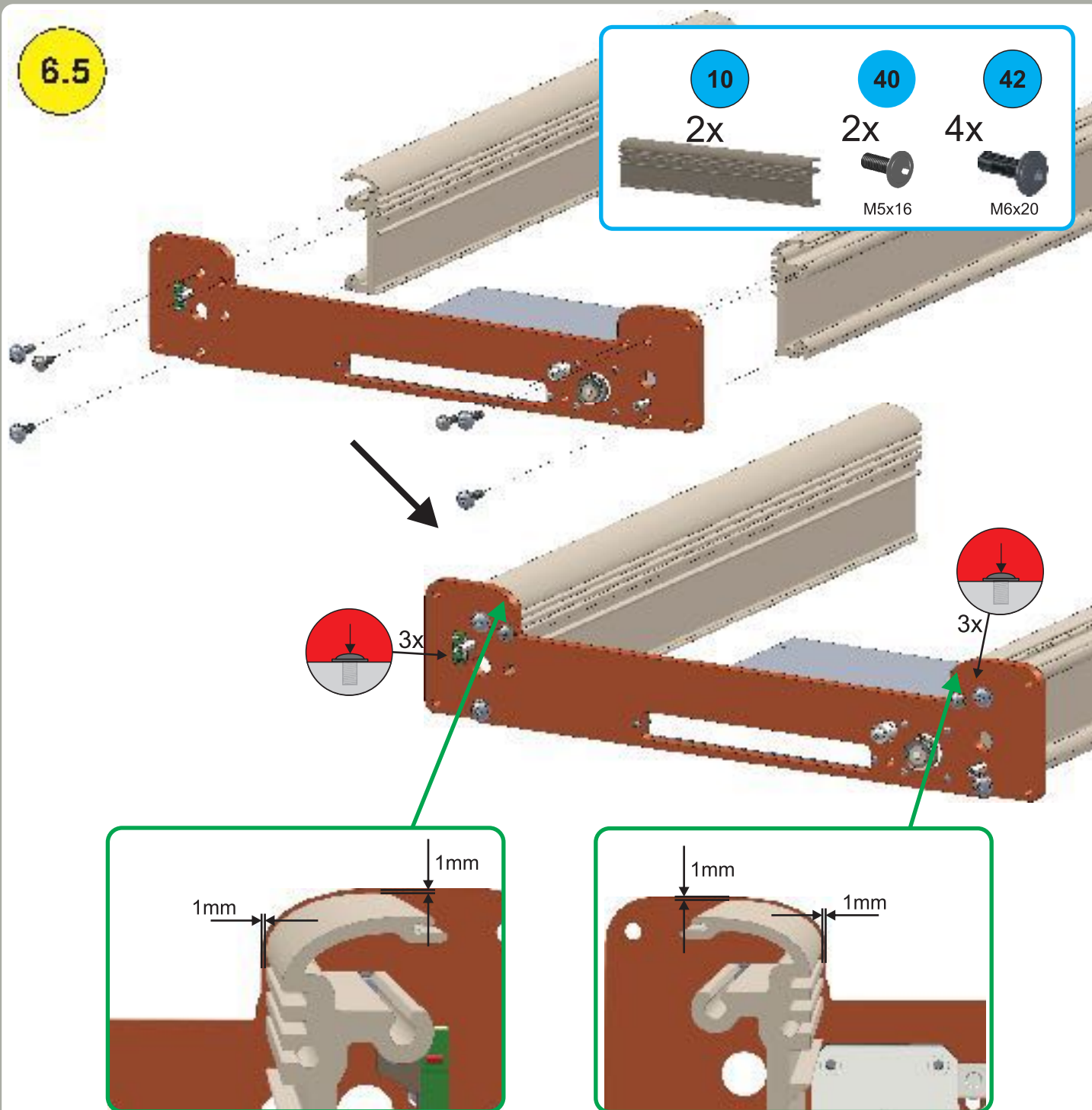
6.3



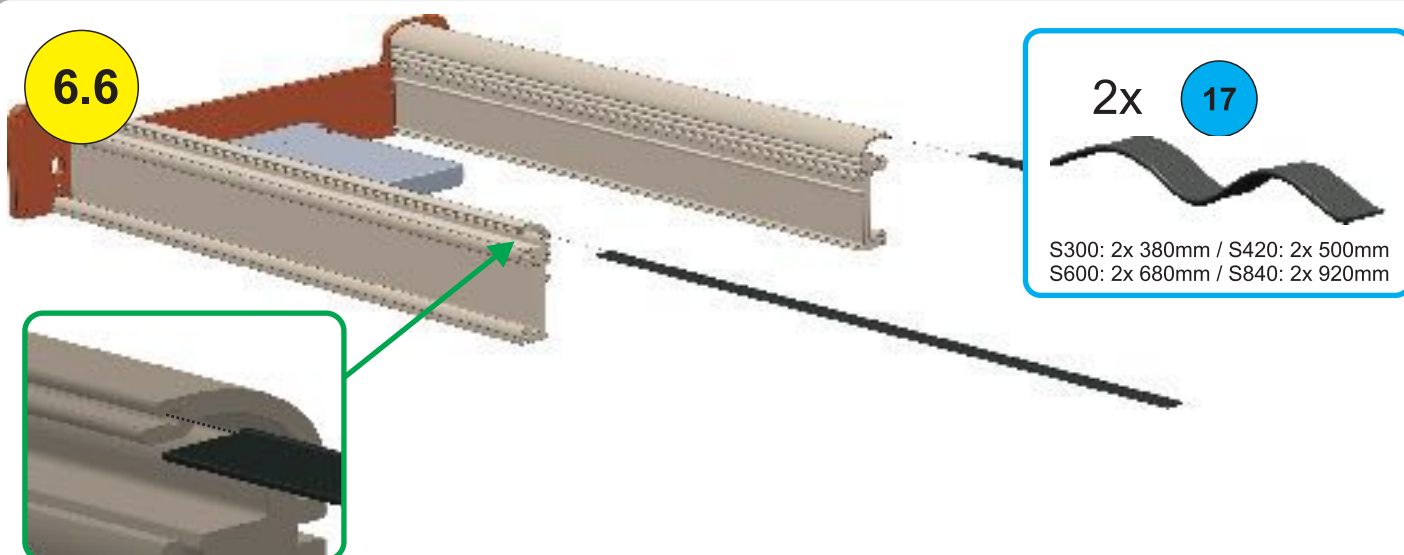
6.4



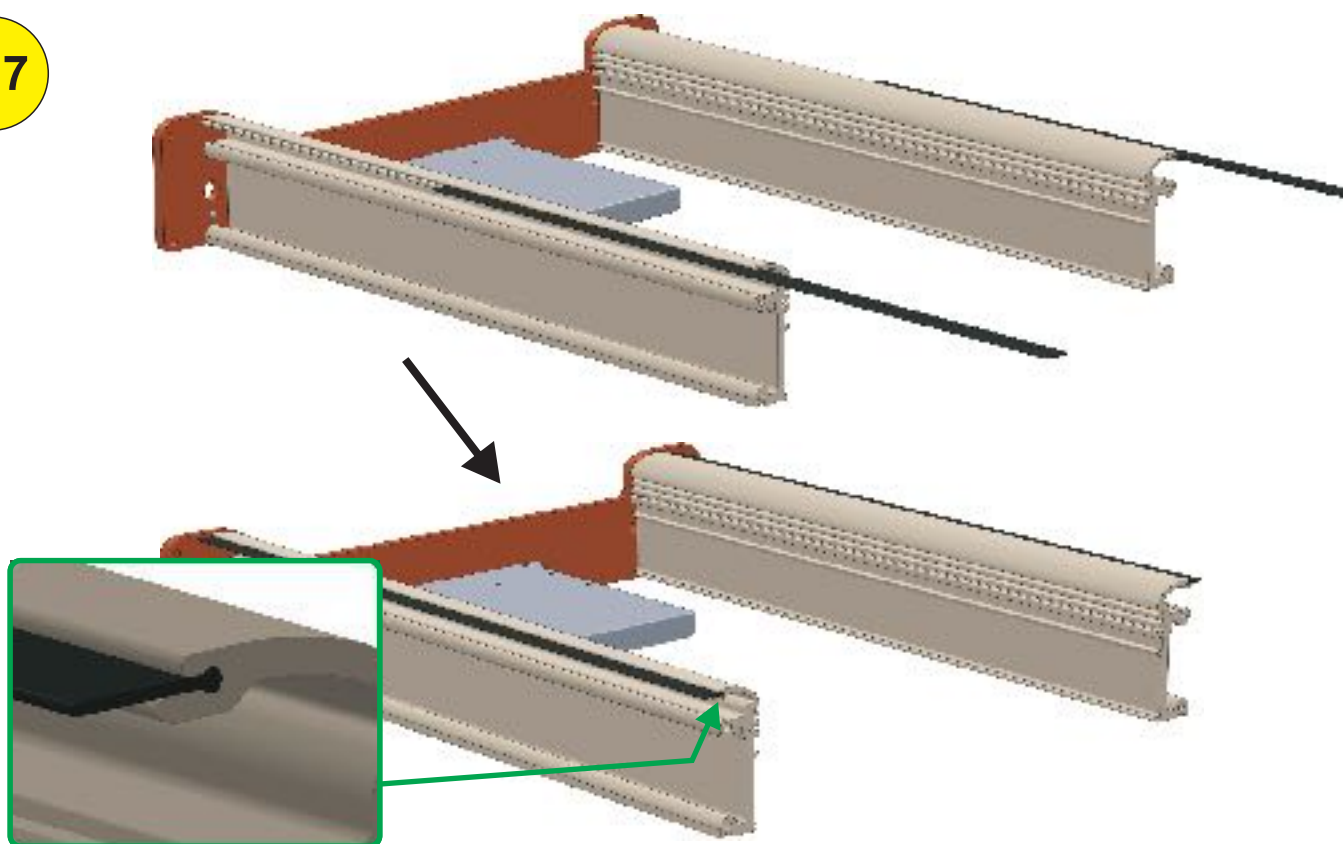
6.5



6.6

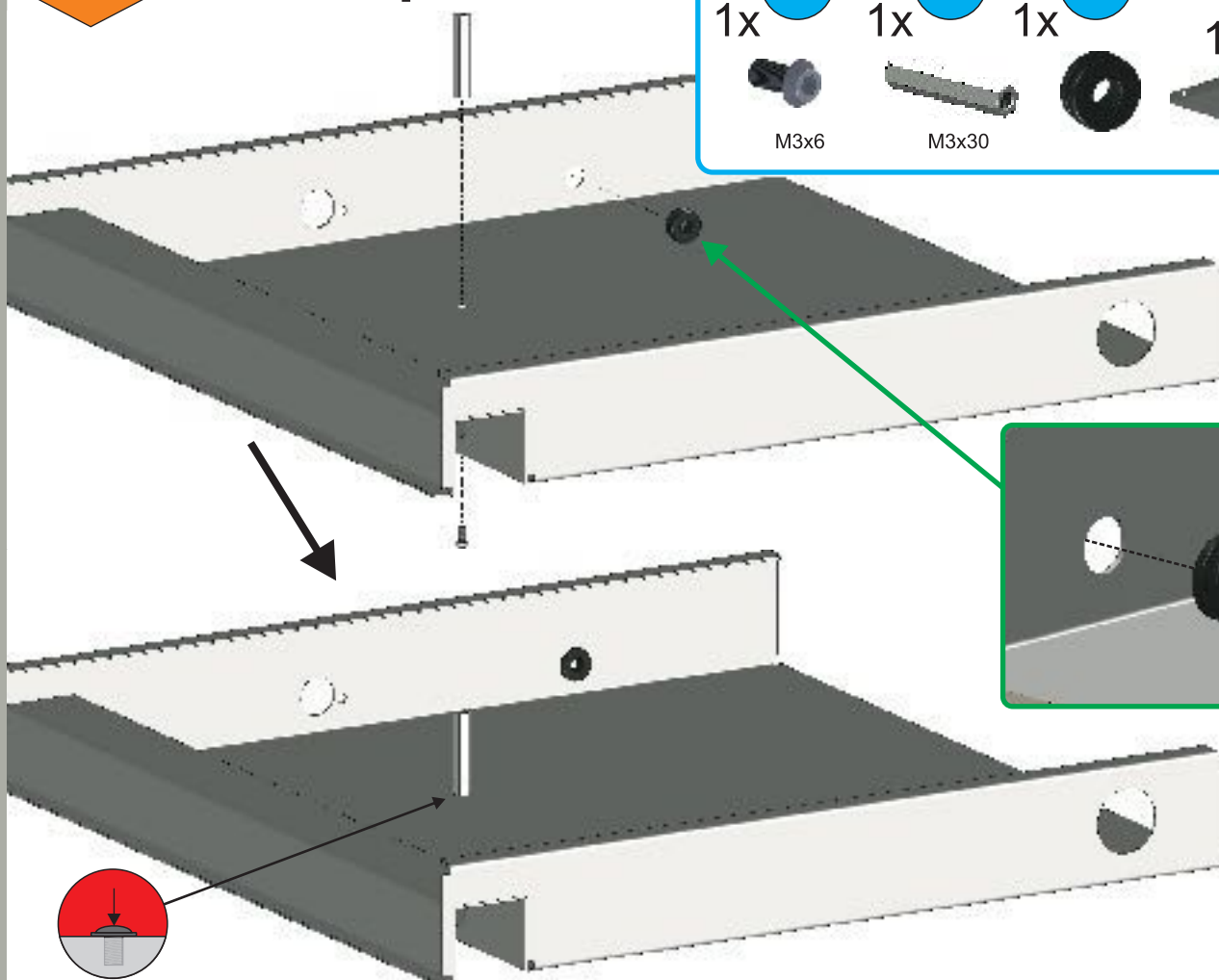
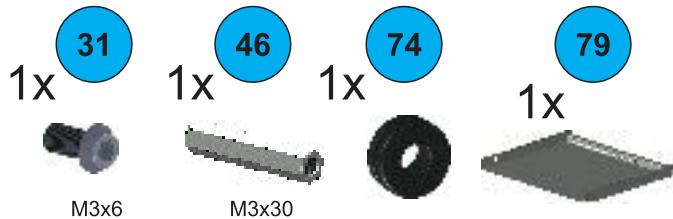


6.7

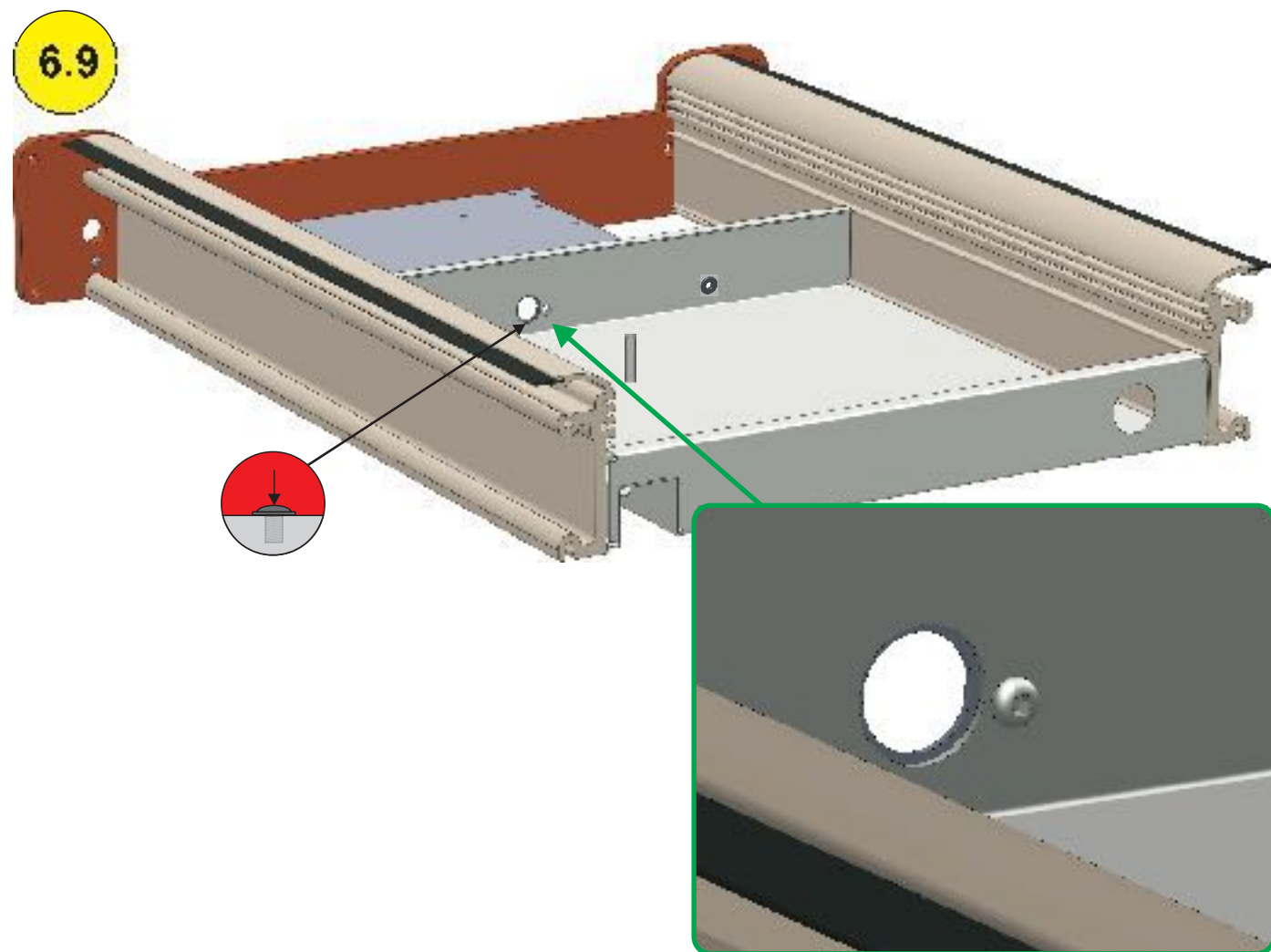
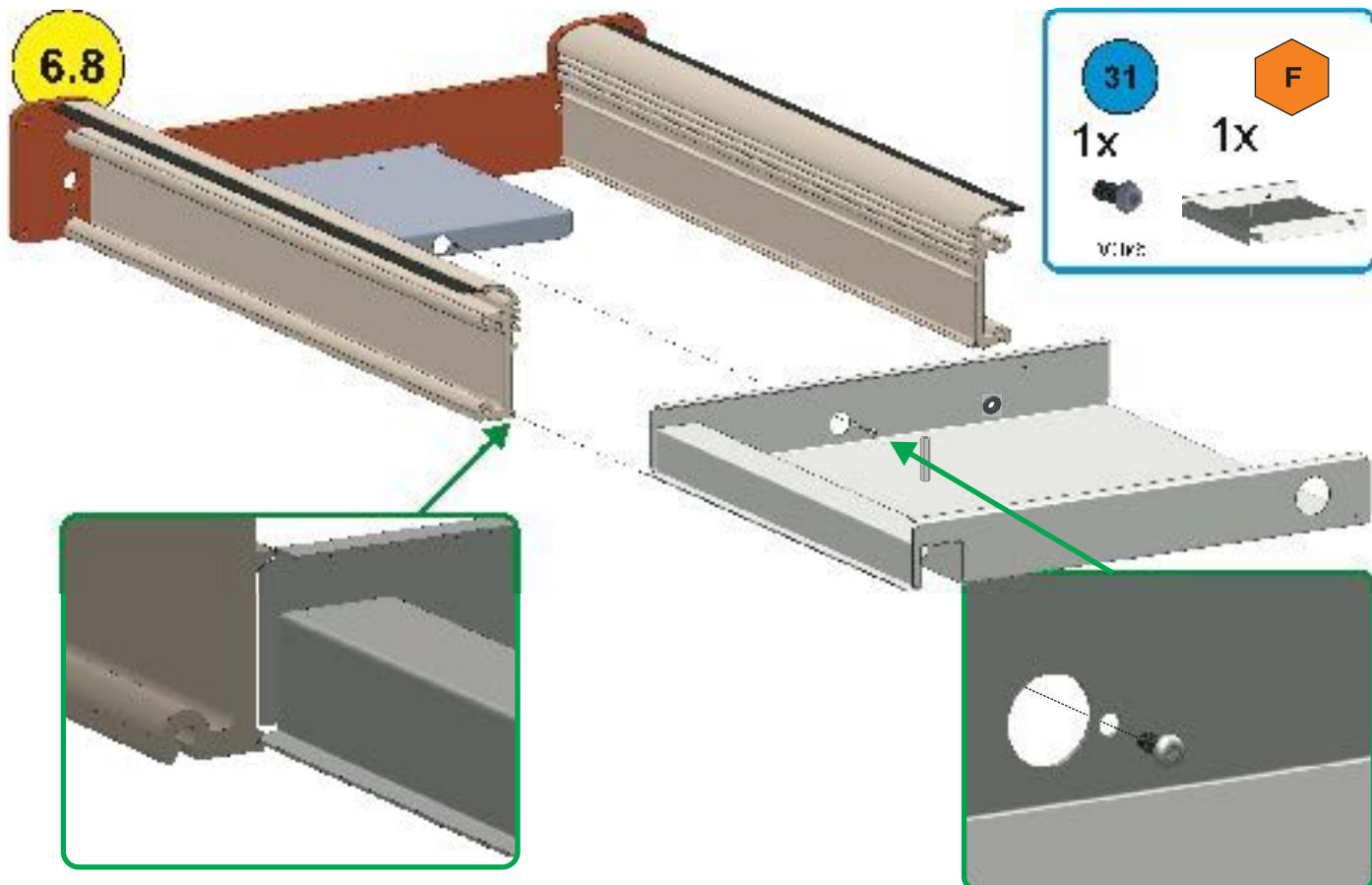


F

## Bottom plate



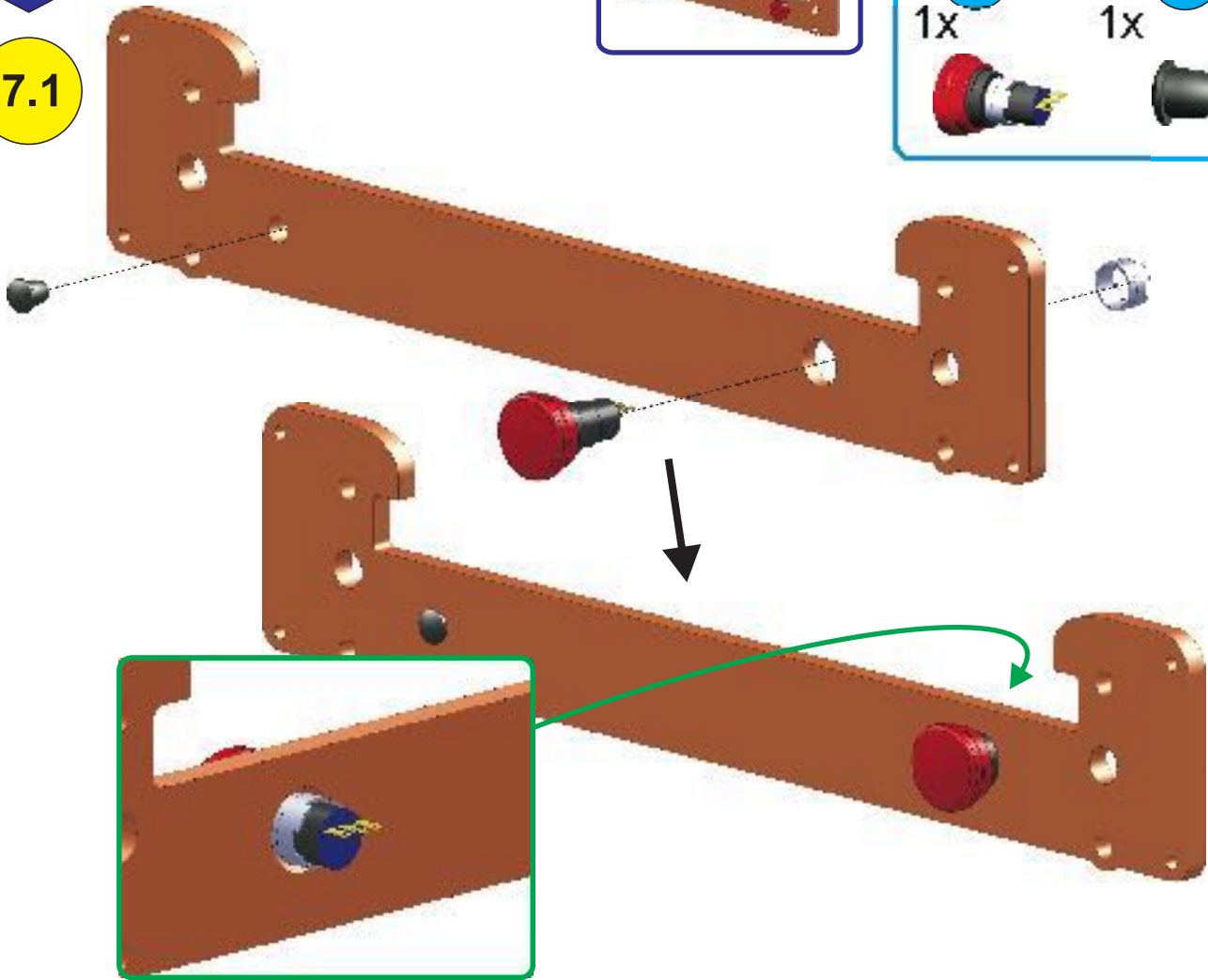
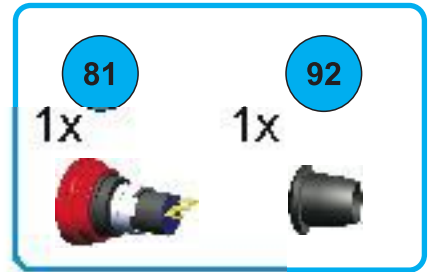
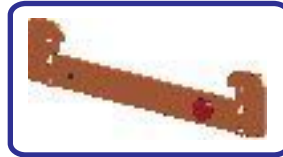






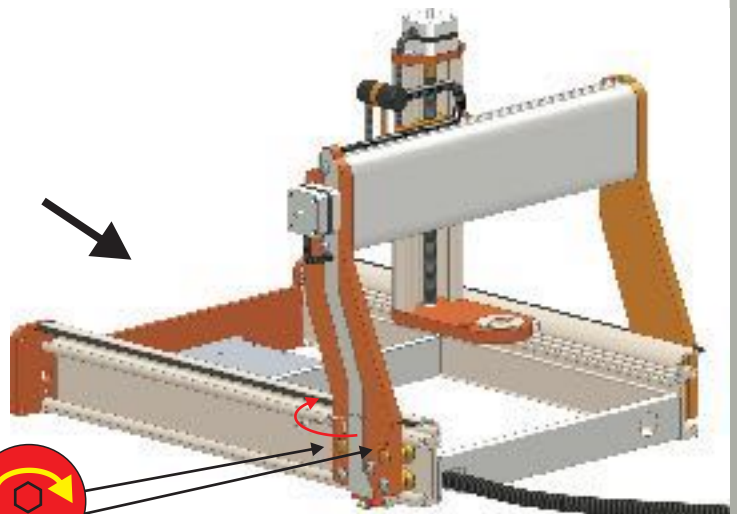
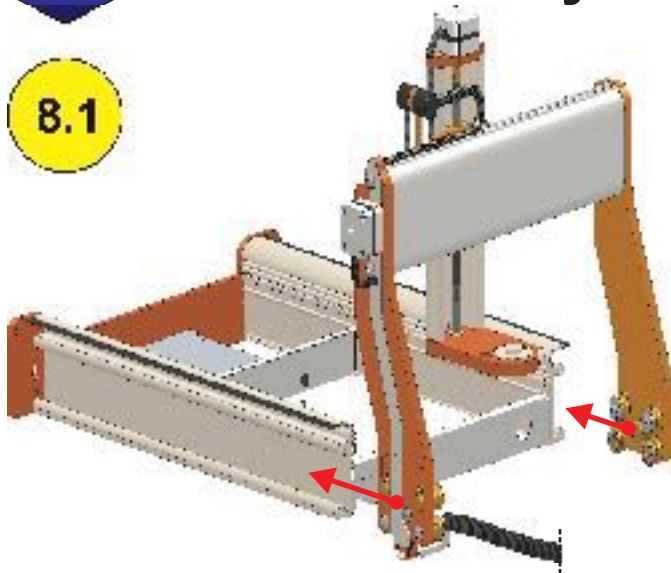
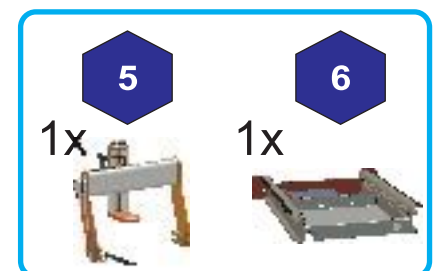
## 7 Front panel

7.1



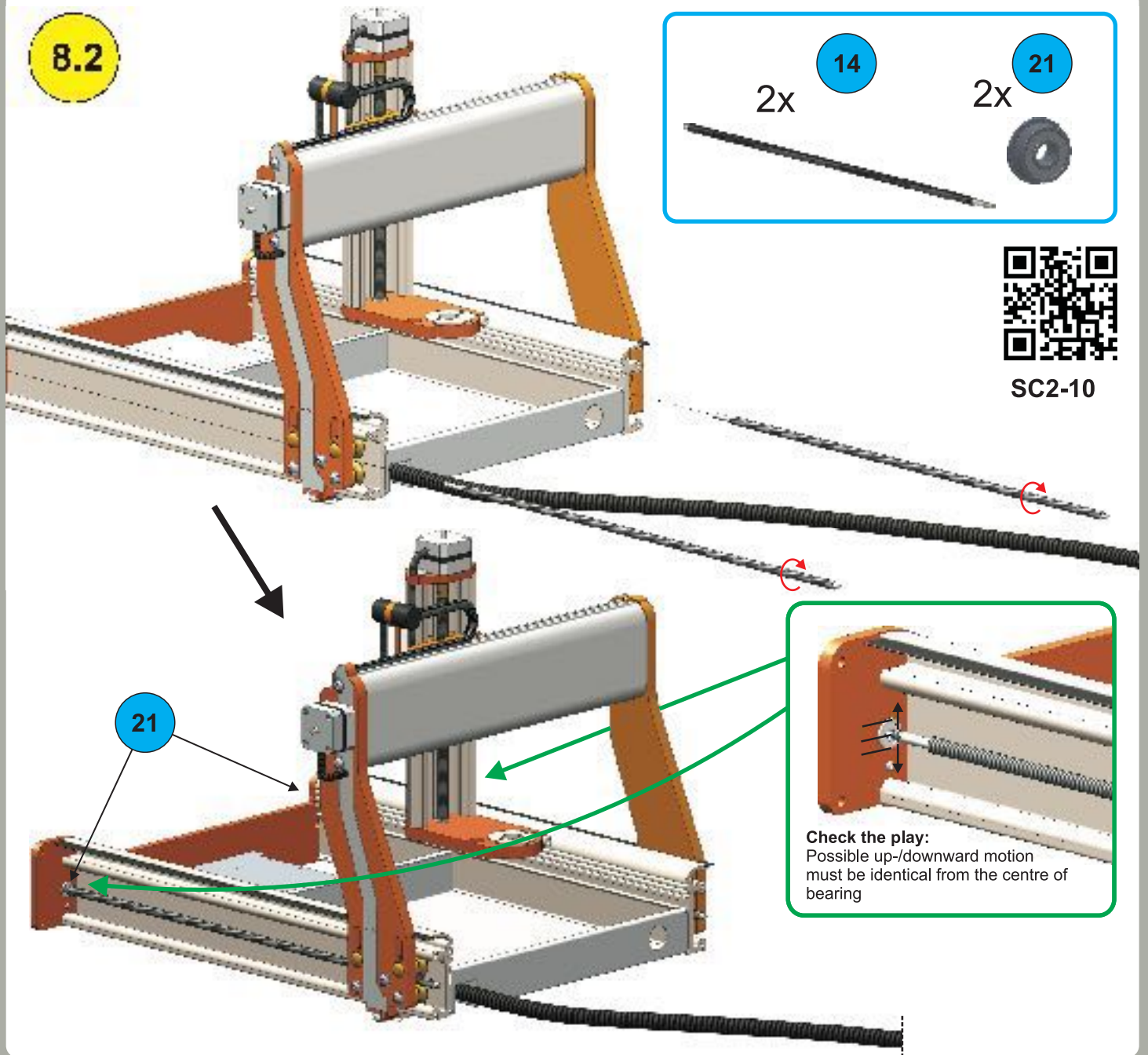
## 8 Final assembly

8.1

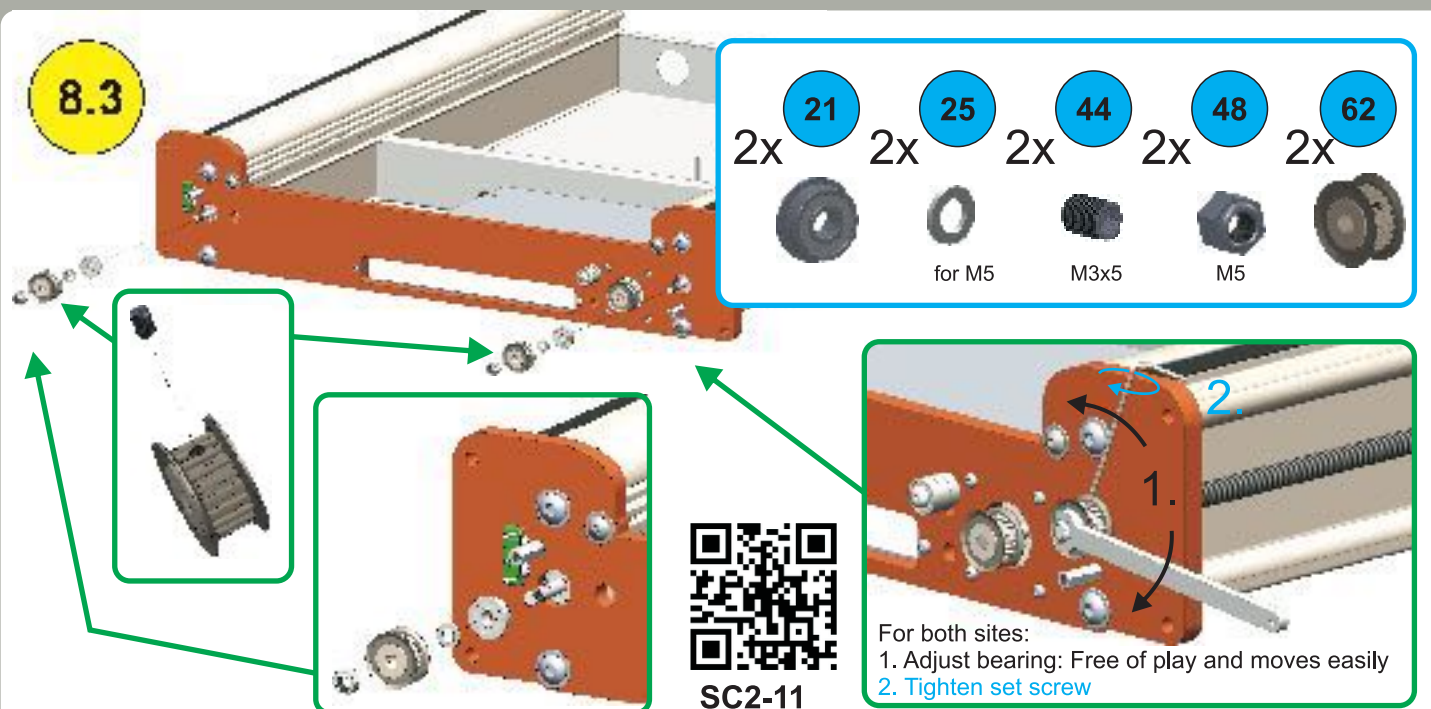


2 screws on each site!

8.2



8.3



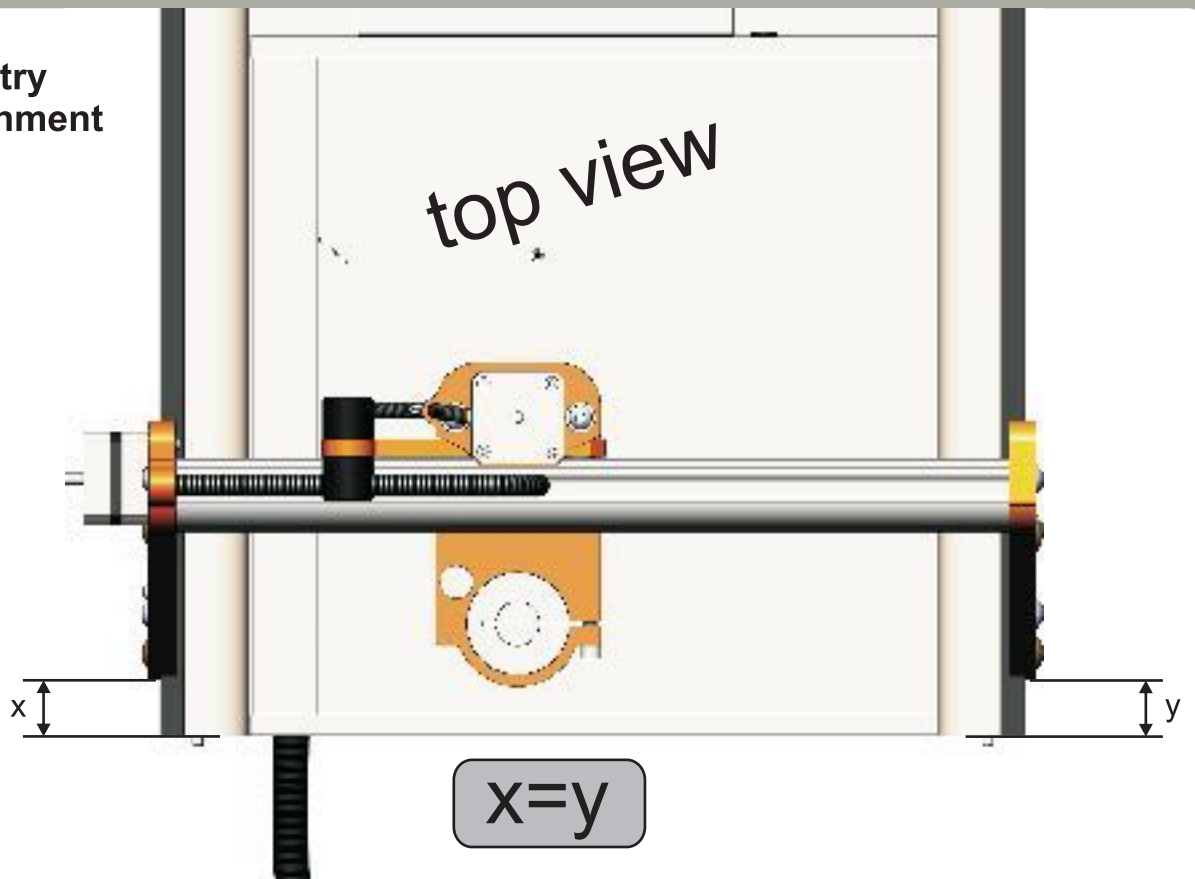


## 8.4

### Gantry alignment



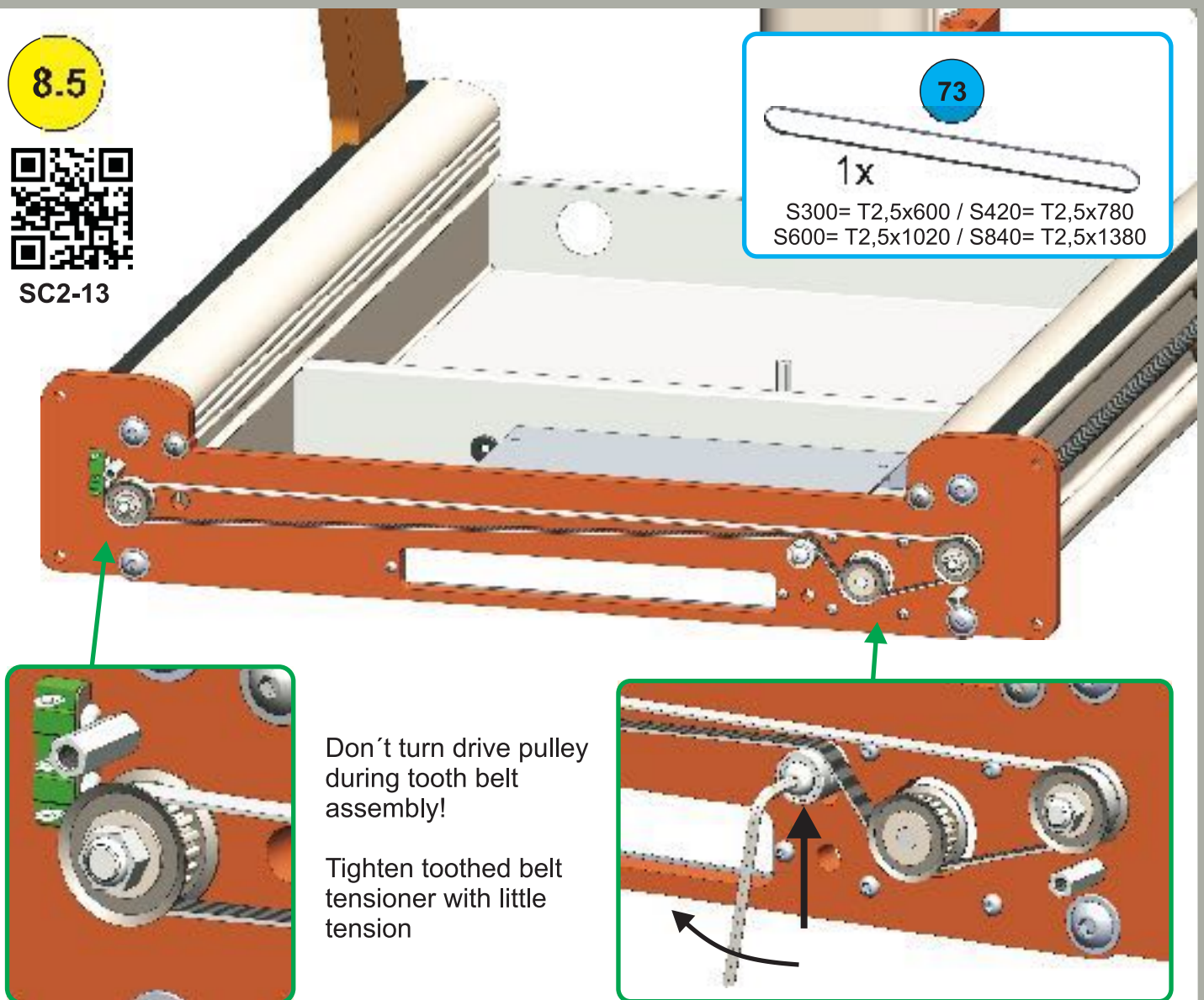
SC2-12



## 8.5

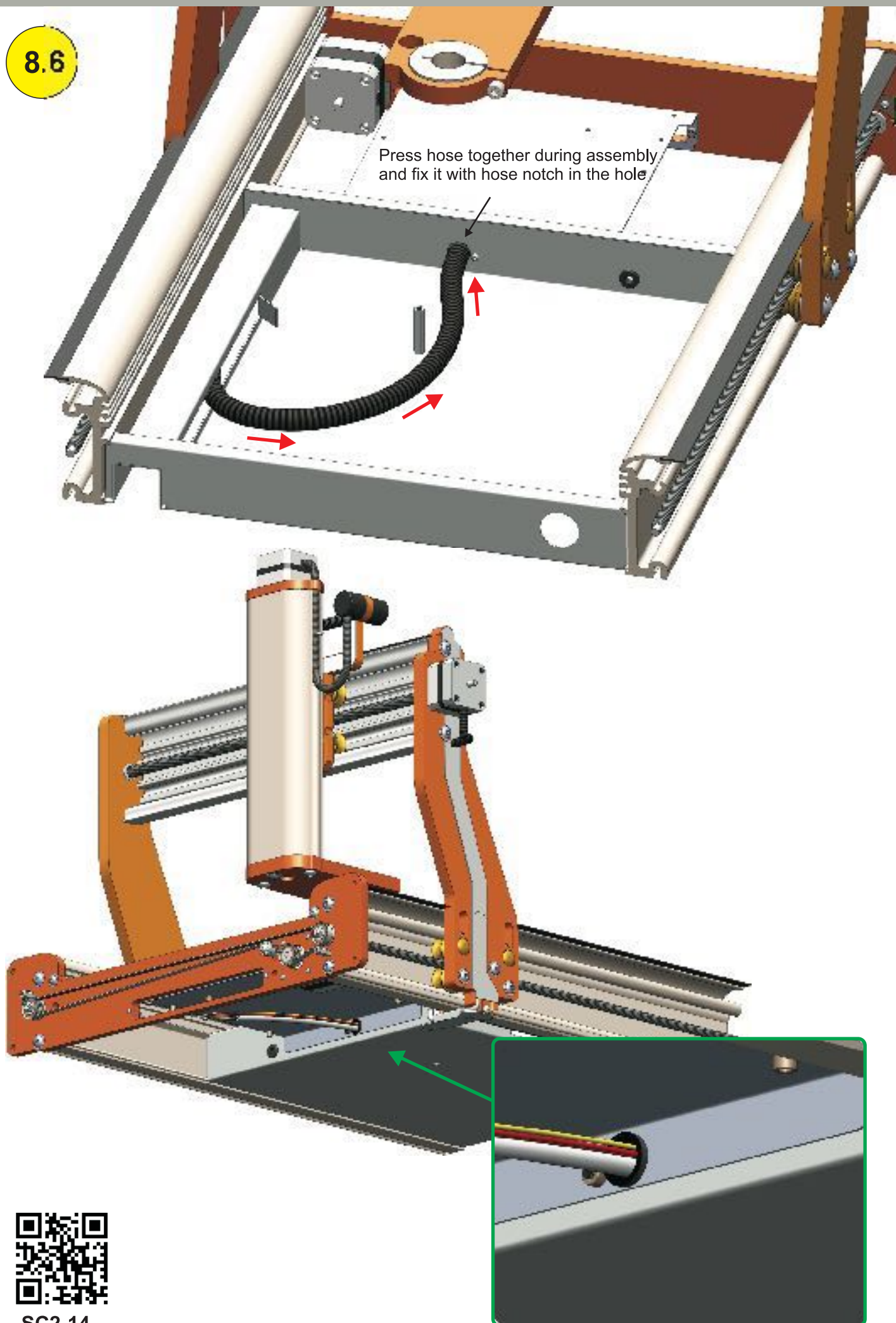


SC2-13



8.6

Press hose together during assembly  
and fix it with hose notch in the hole

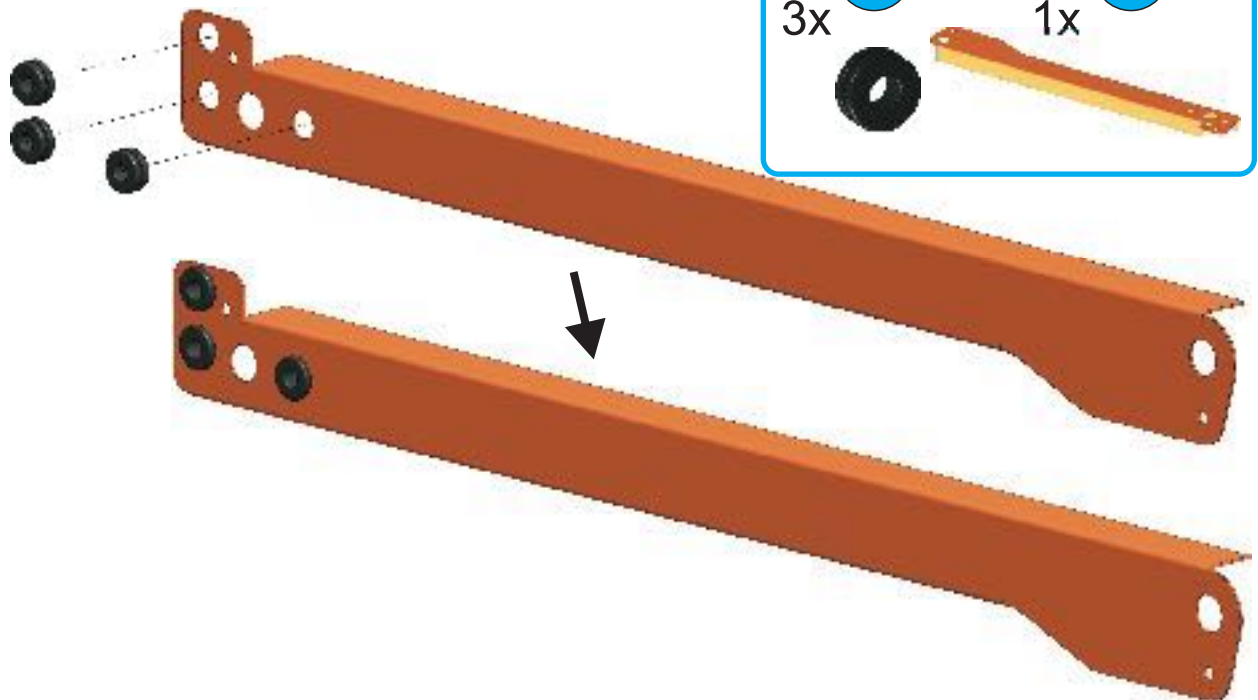


SC2-14

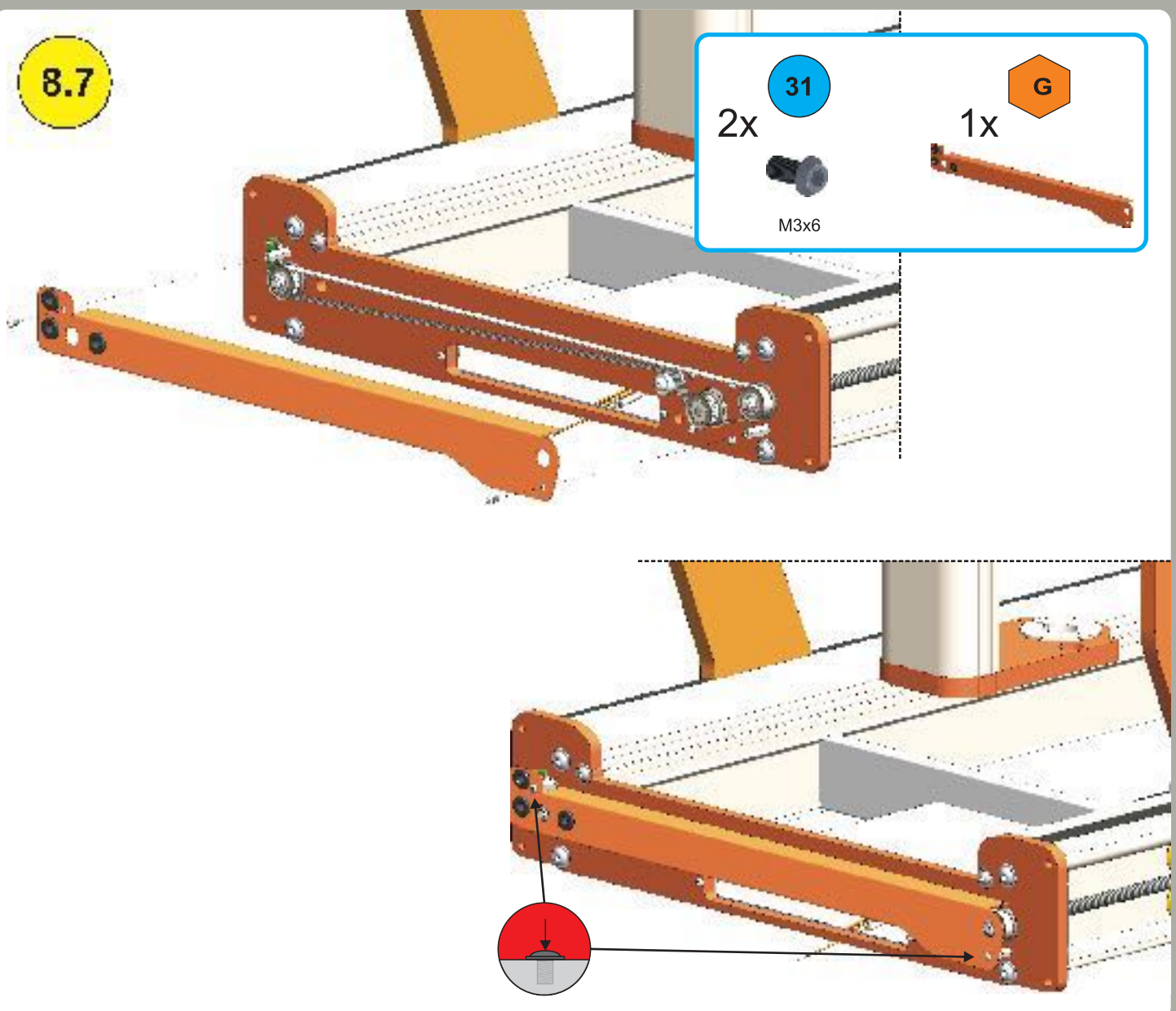




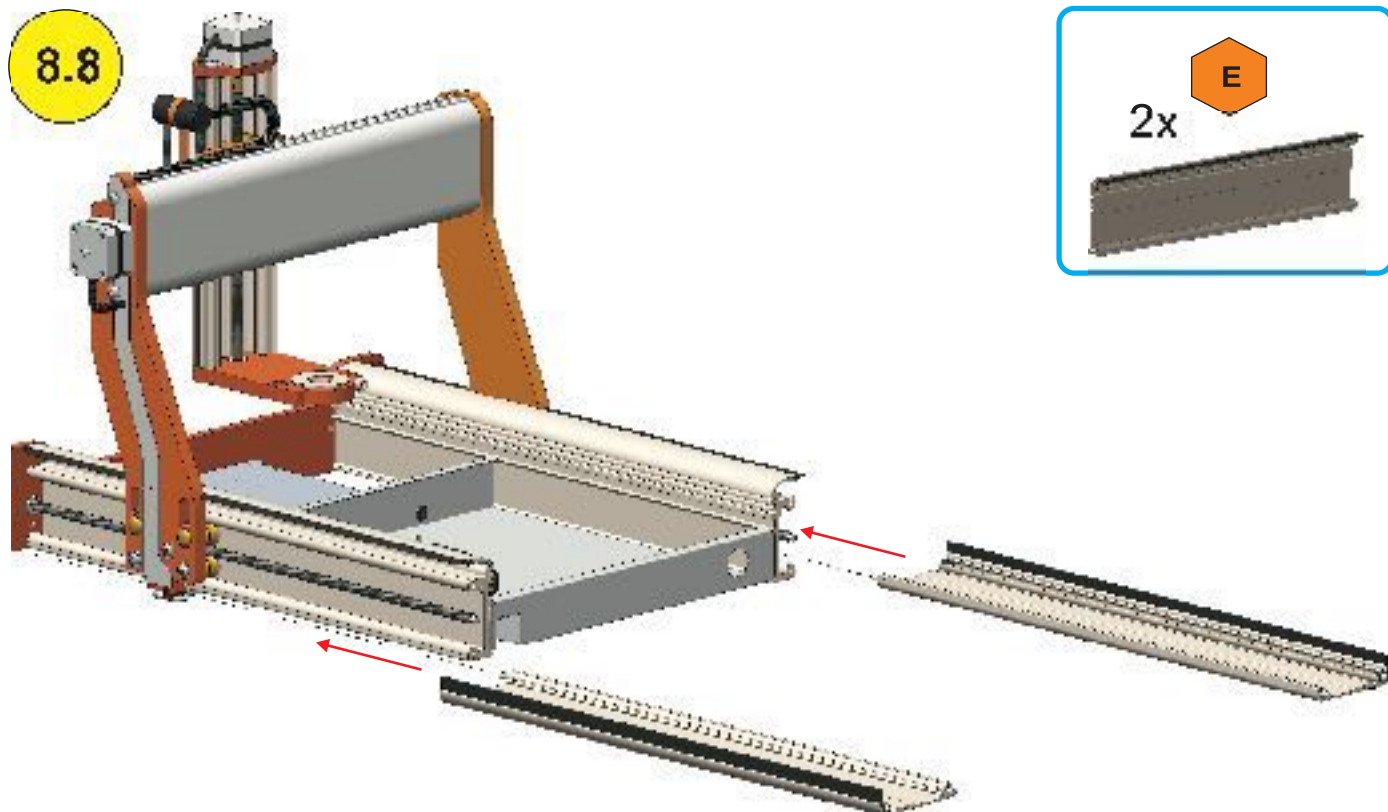
## Tooth belt cover



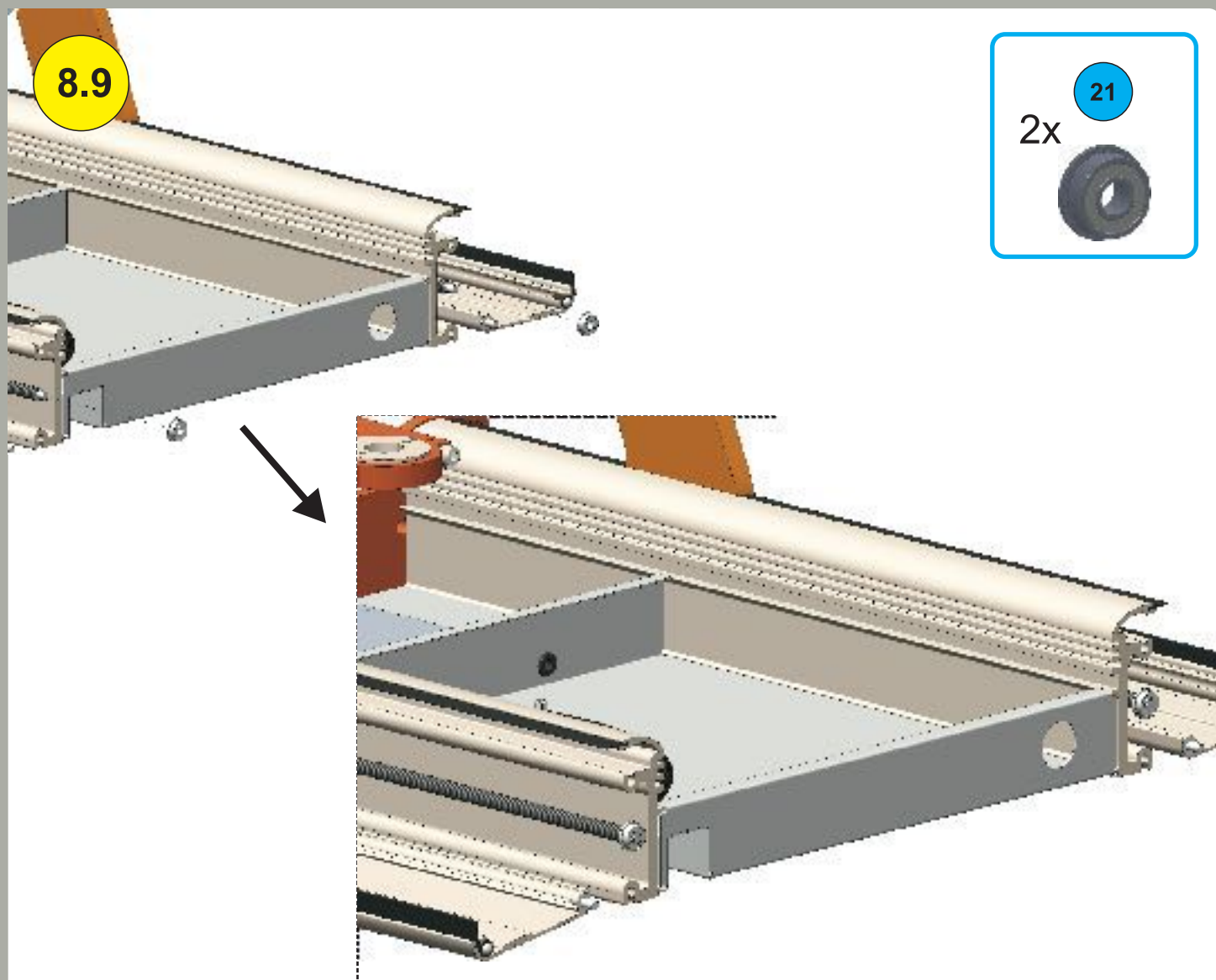
8.7



8.8

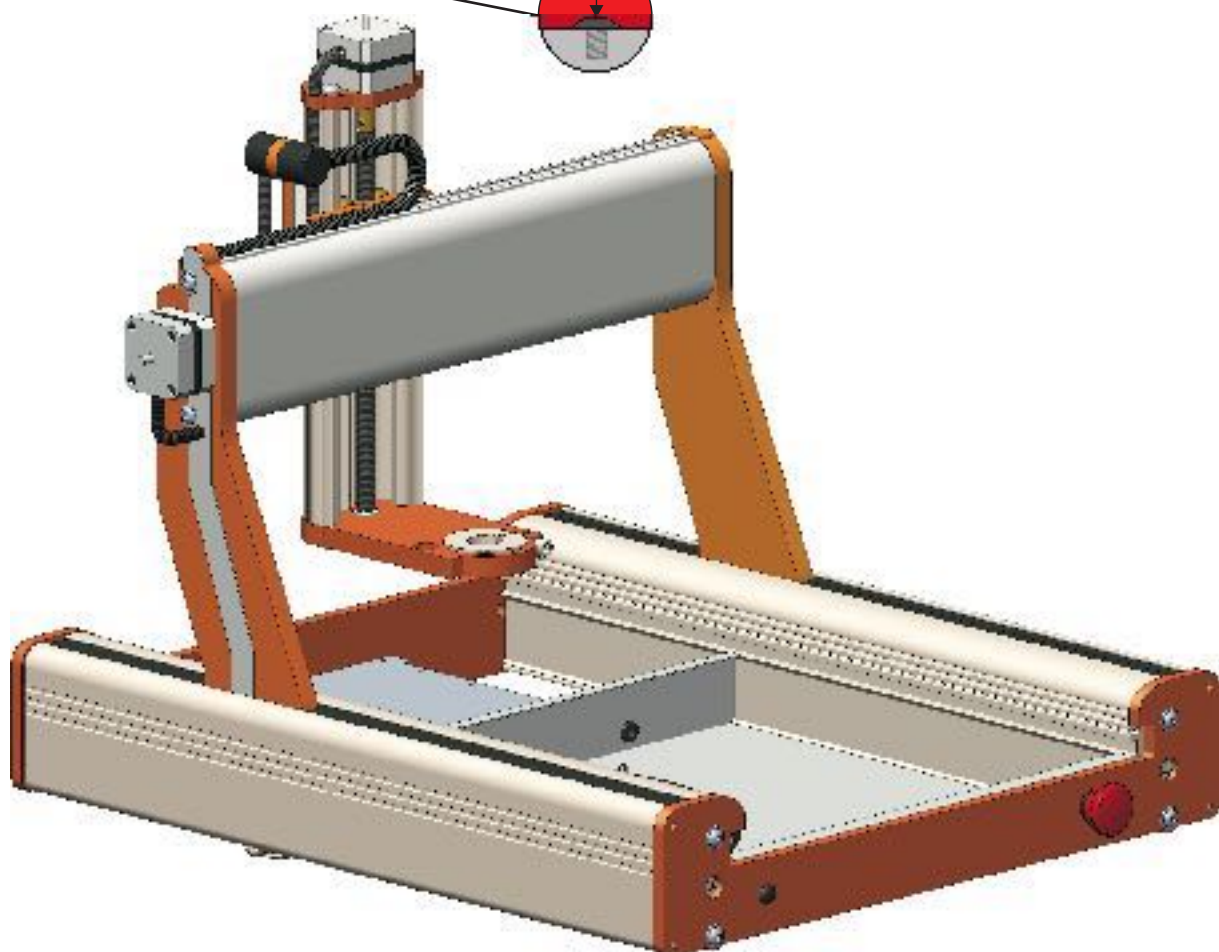
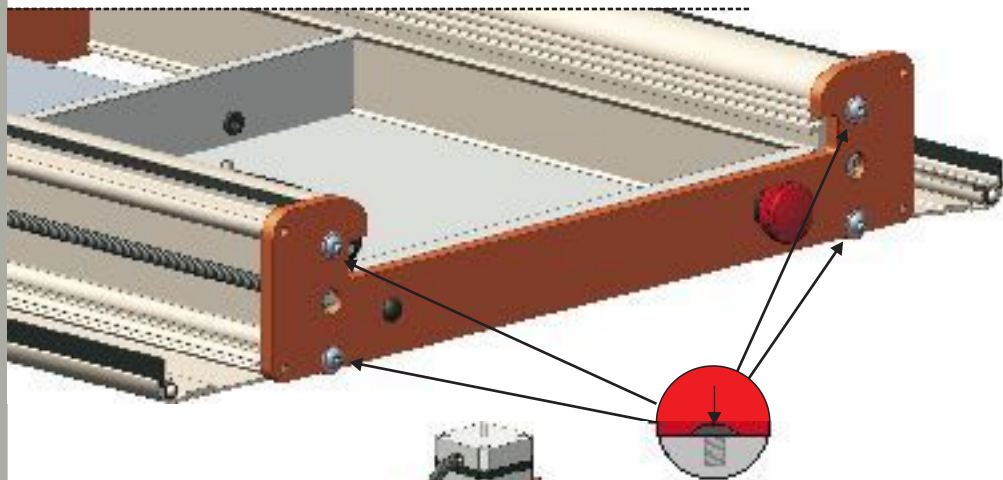
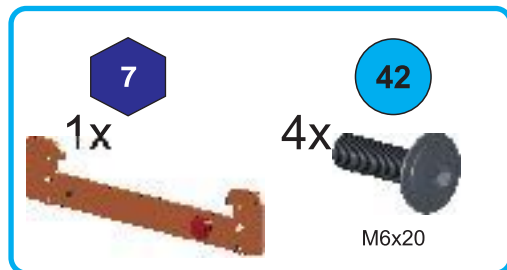


8.9





8.10



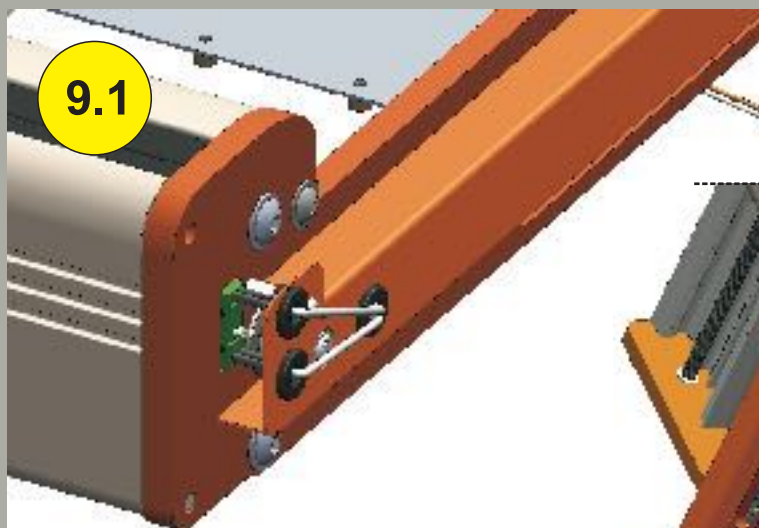


9



## Installation and wiring of control unit

9.1

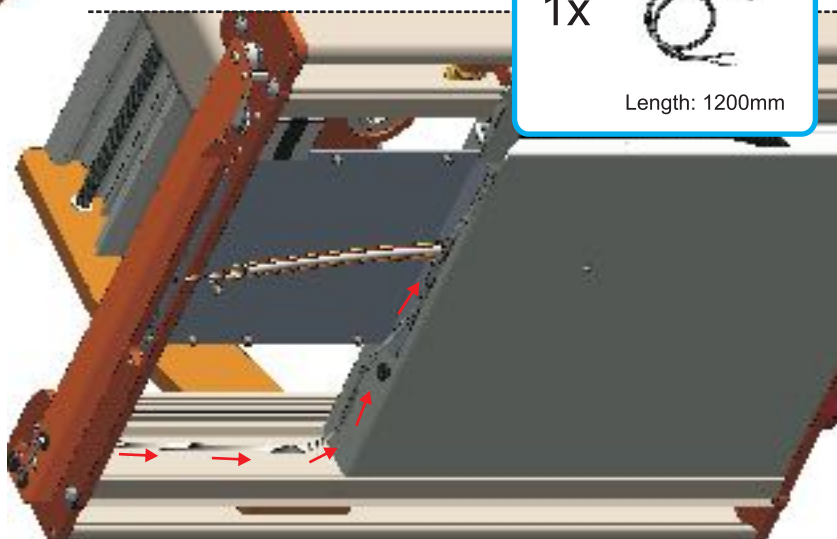


86

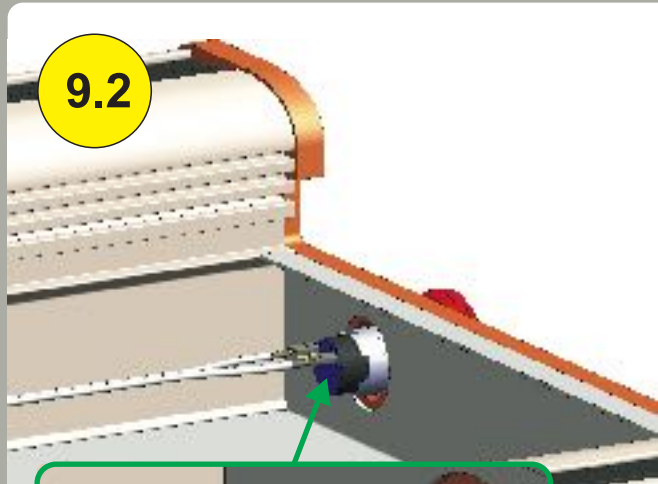
1x



Length: 1200mm



9.2

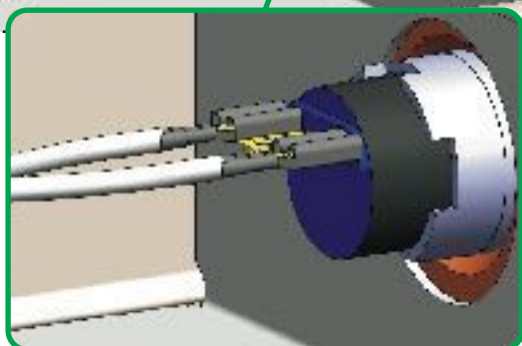
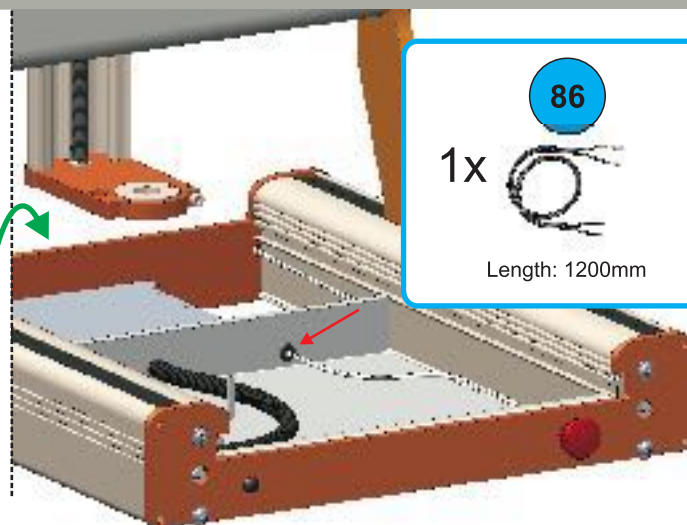


86

1x



Length: 1200mm



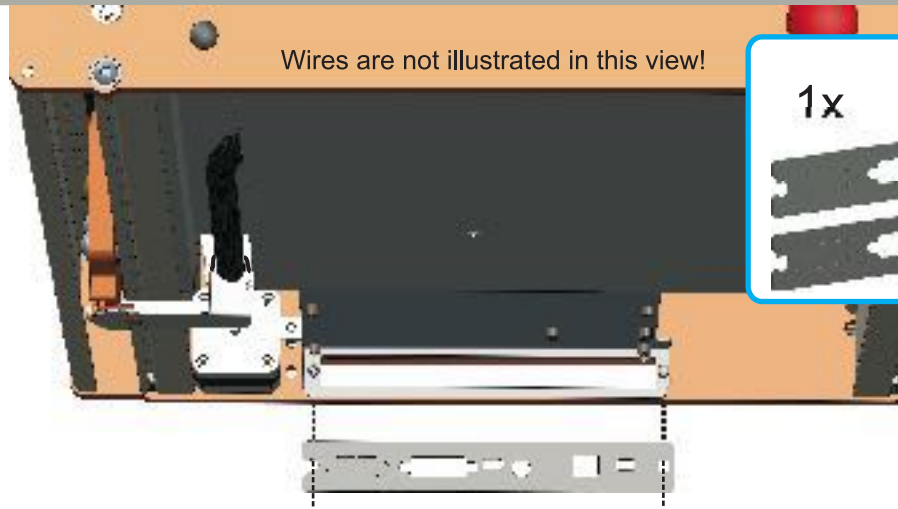
9.3

Wires are not illustrated in this view!

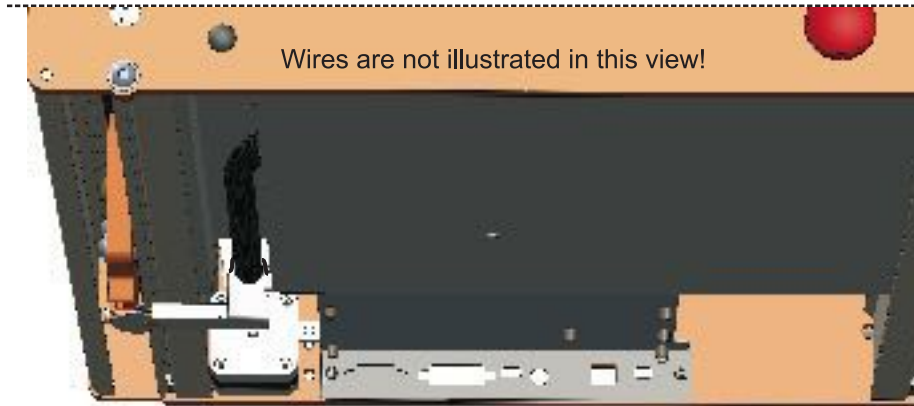
1x

67

or



Wires are not illustrated in this view!



9.4

31

4x



M3x6

50

2x



M3 I-A 13,5

1x

76

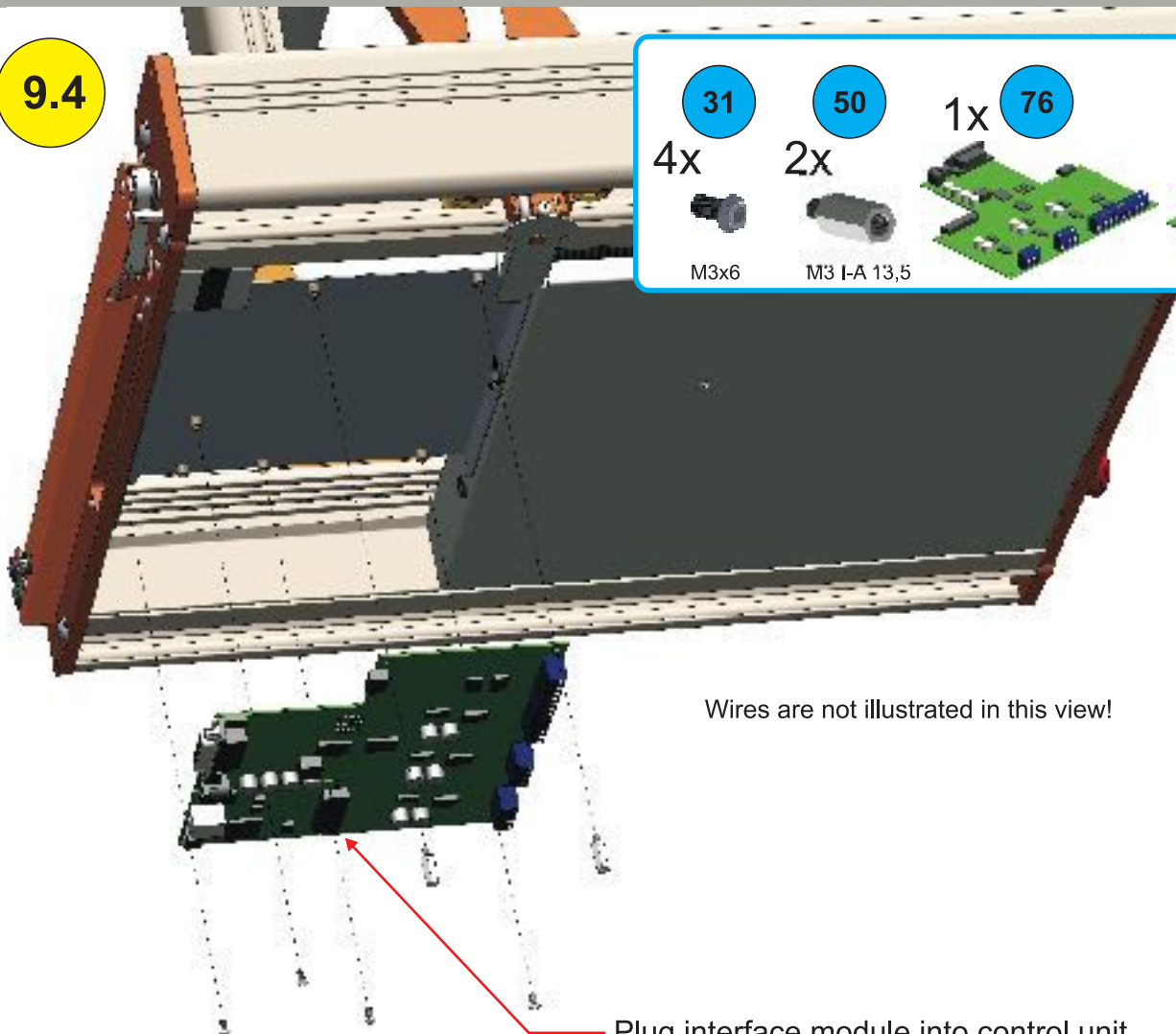


77

1x

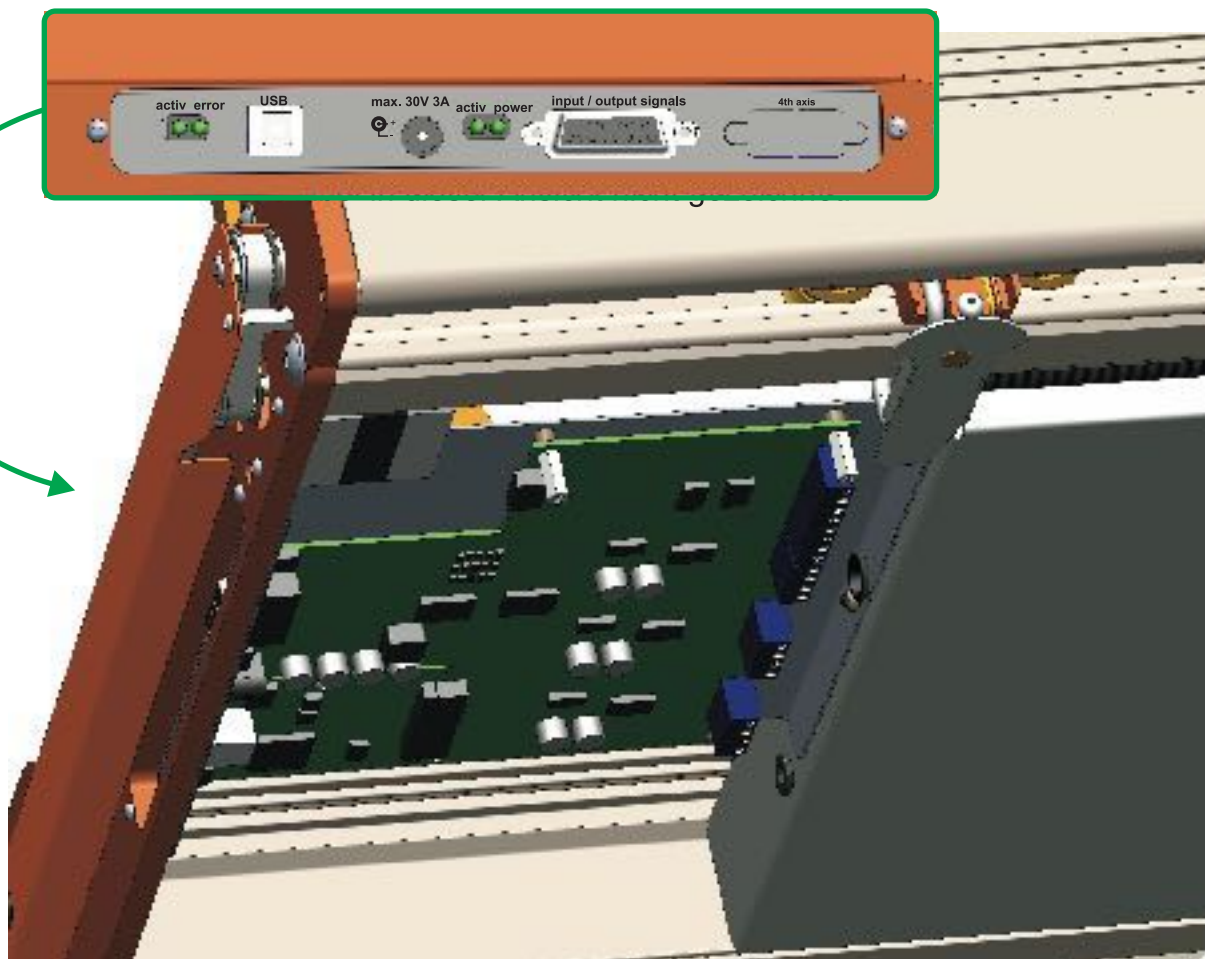


Wires are not illustrated in this view!



Plug interface module into control unit

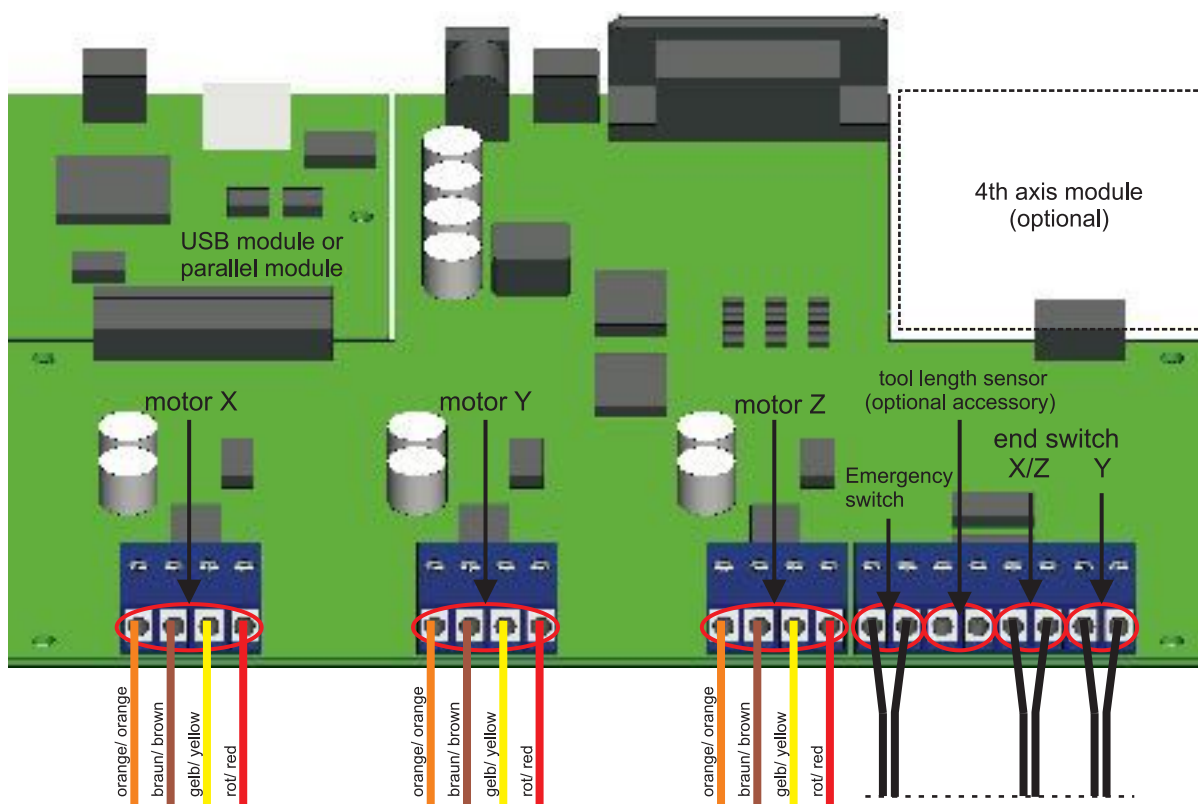
9.5



9.6

## Wiring diagram

Connect all cables according to the wiring diagram.  
Shorten if necessary.

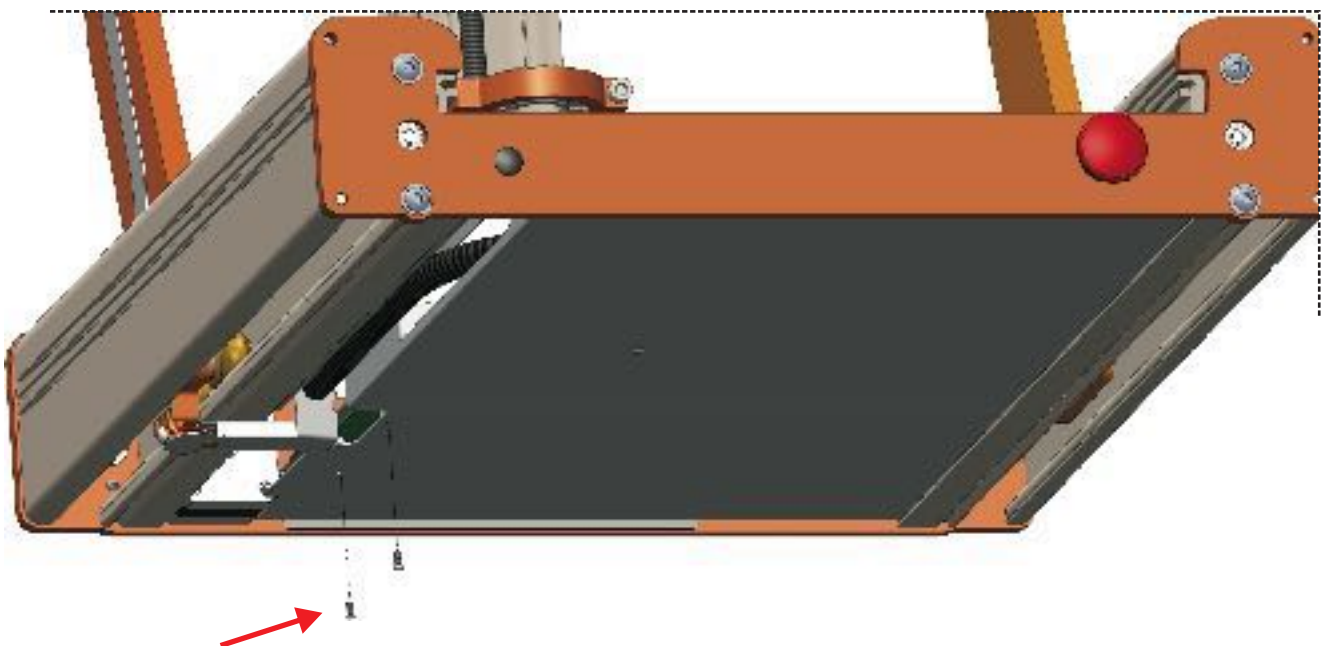
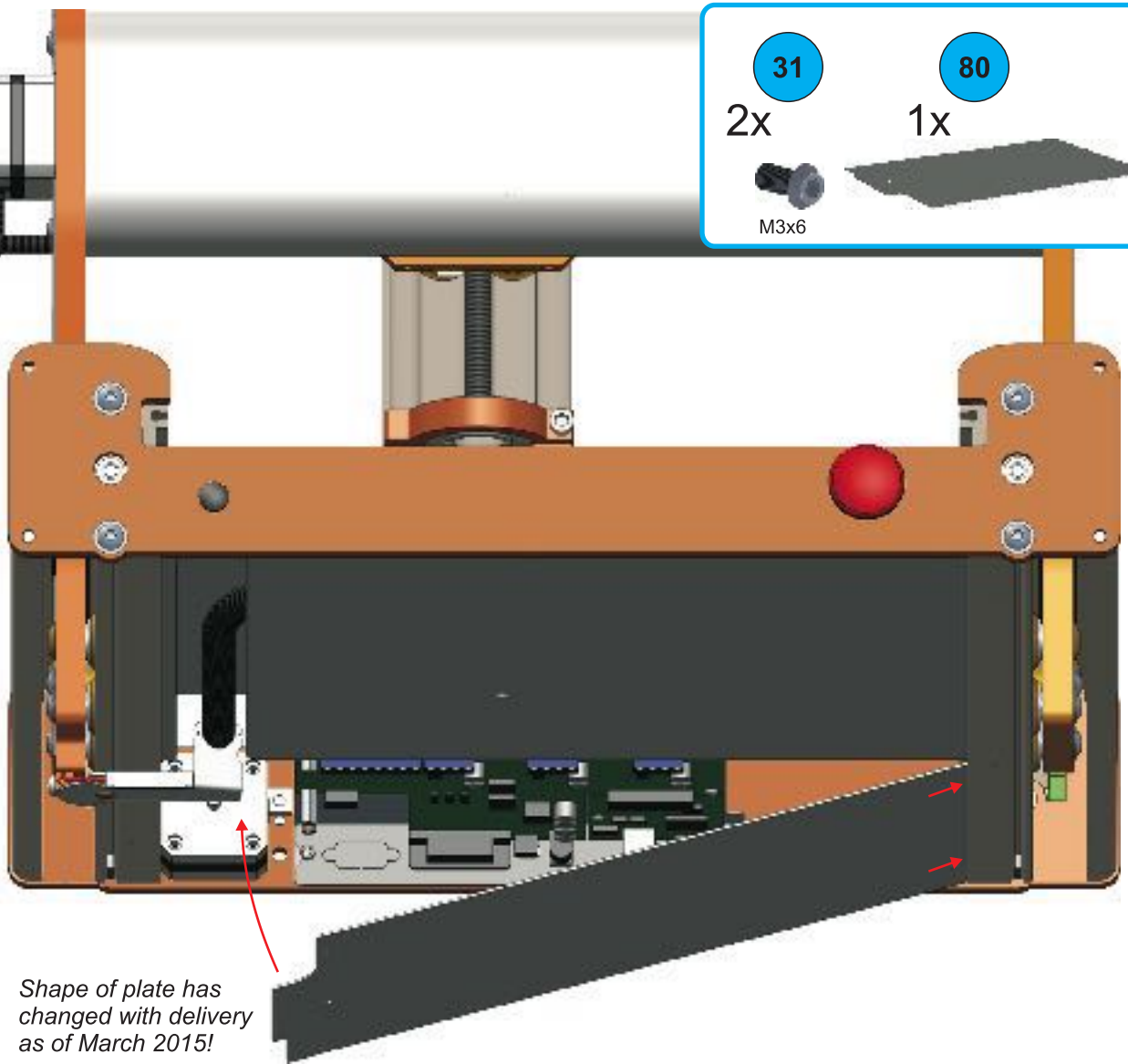




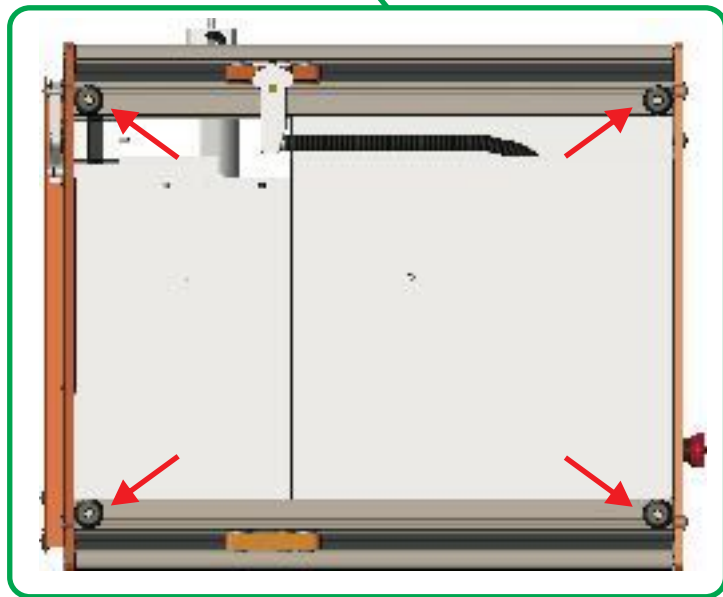
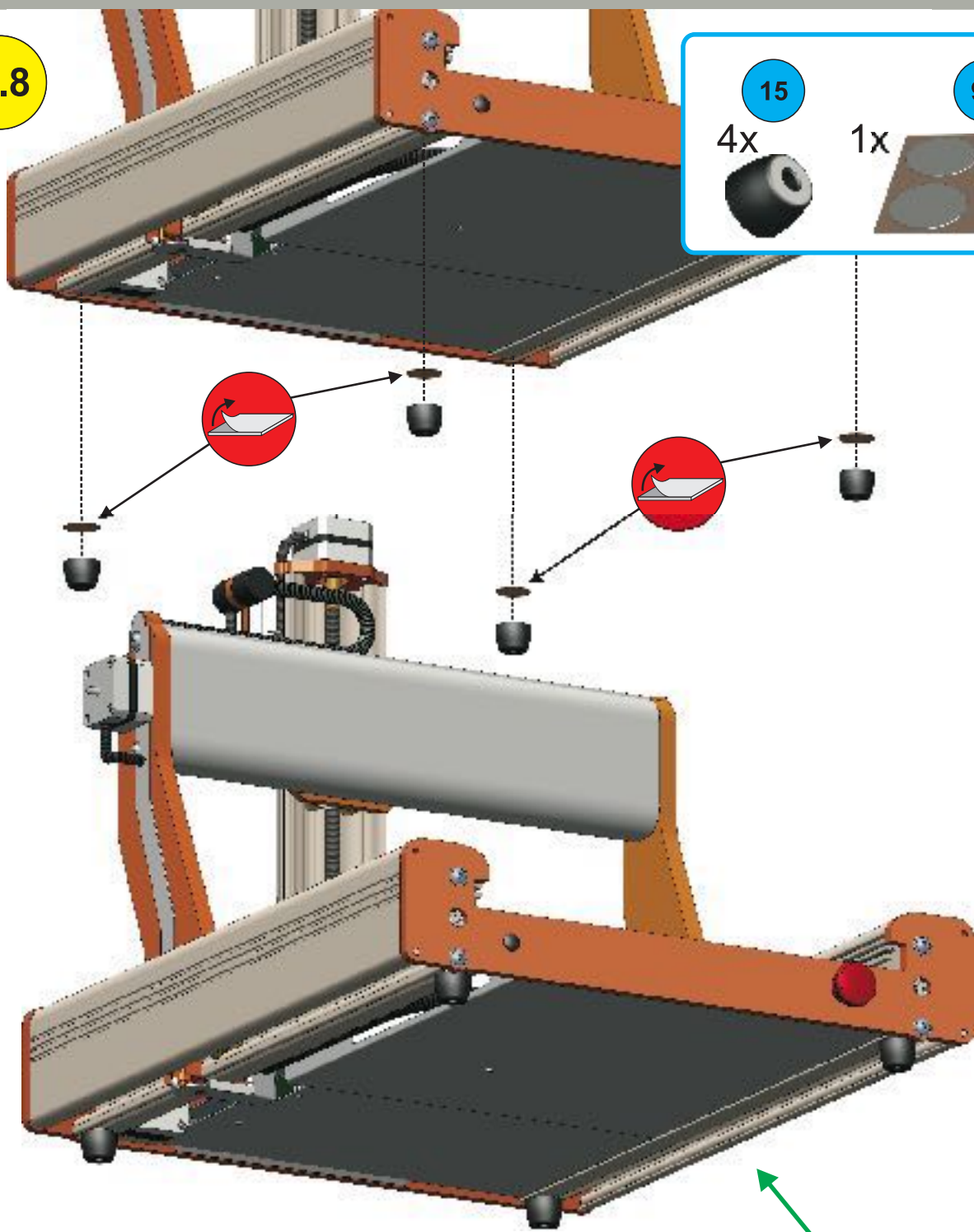
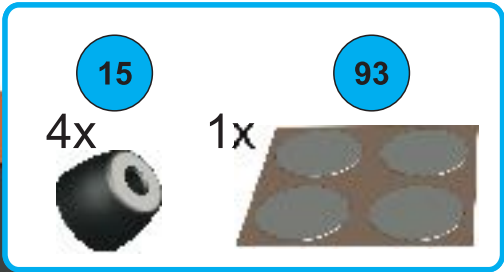
9.7

31  
2x  
M3x6

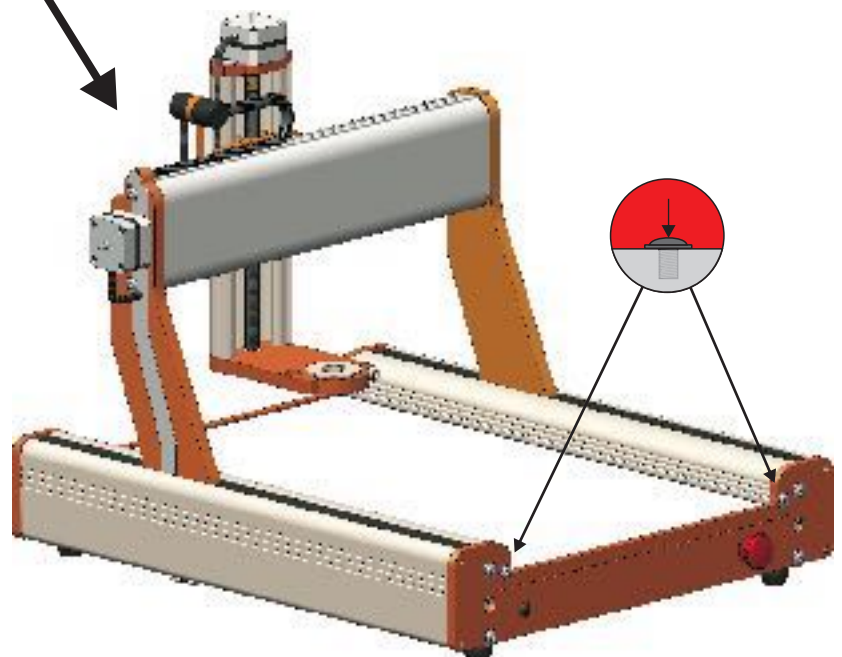
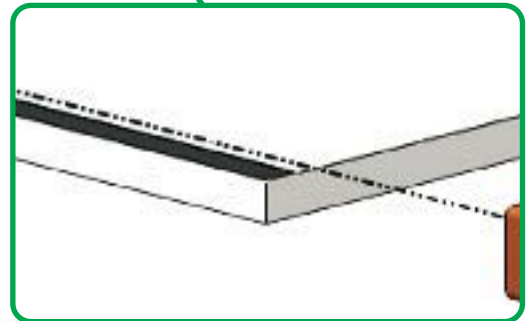
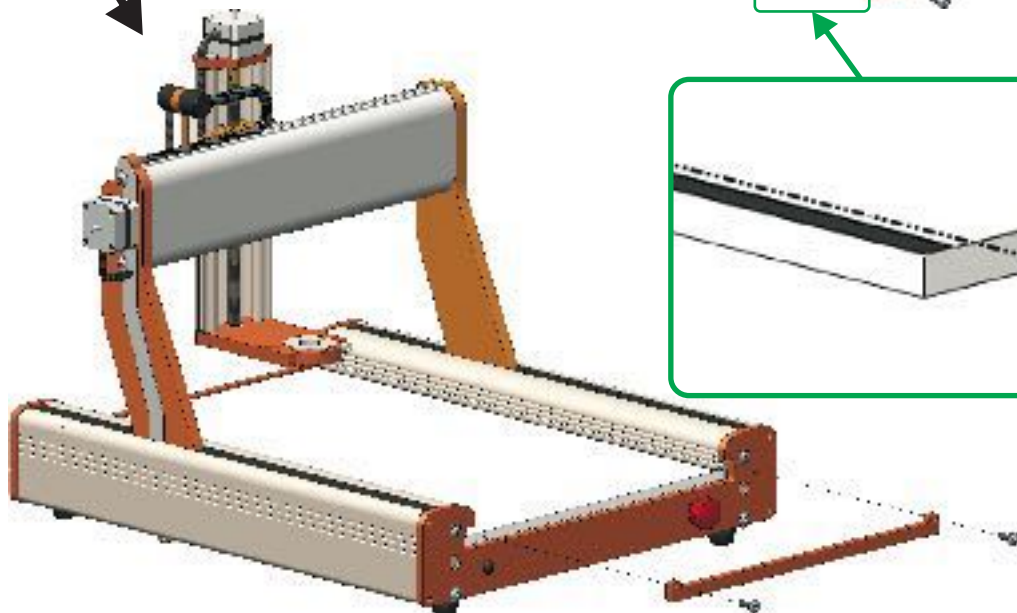
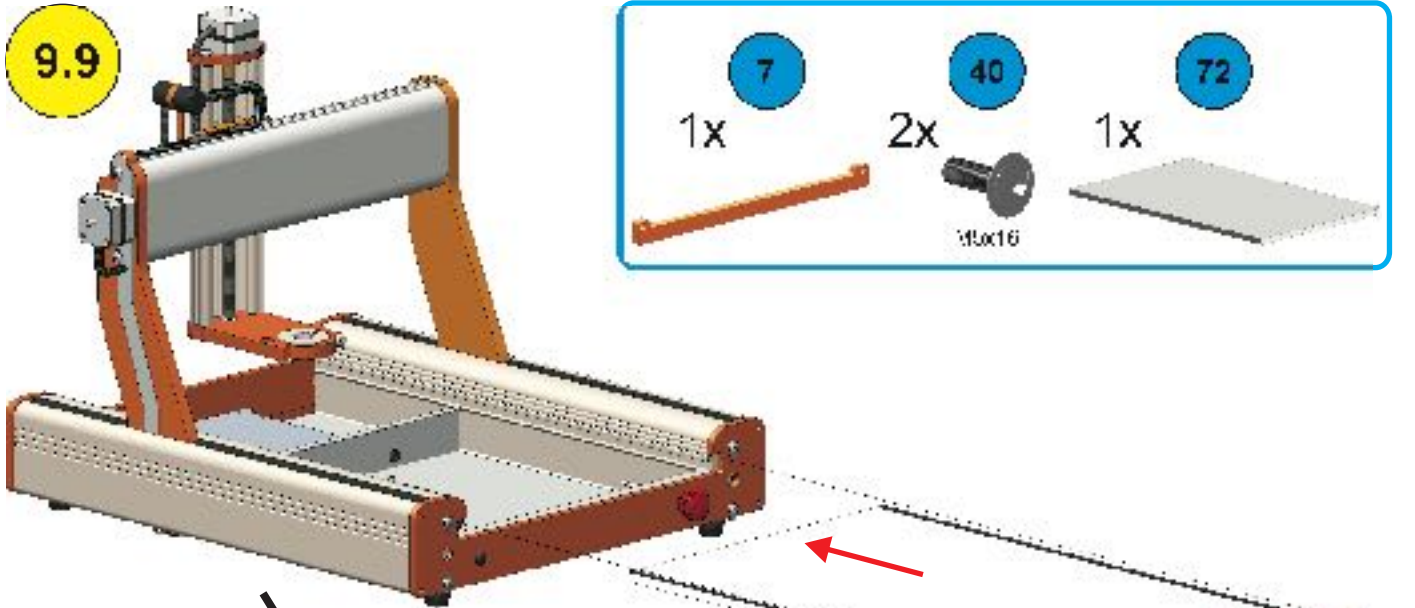
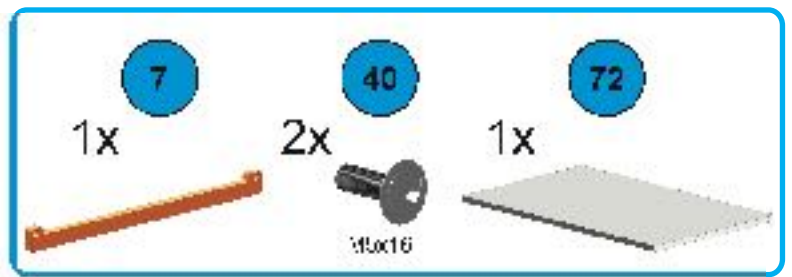
80  
1x



9.8



9.9





10

## Clamping system

10.1

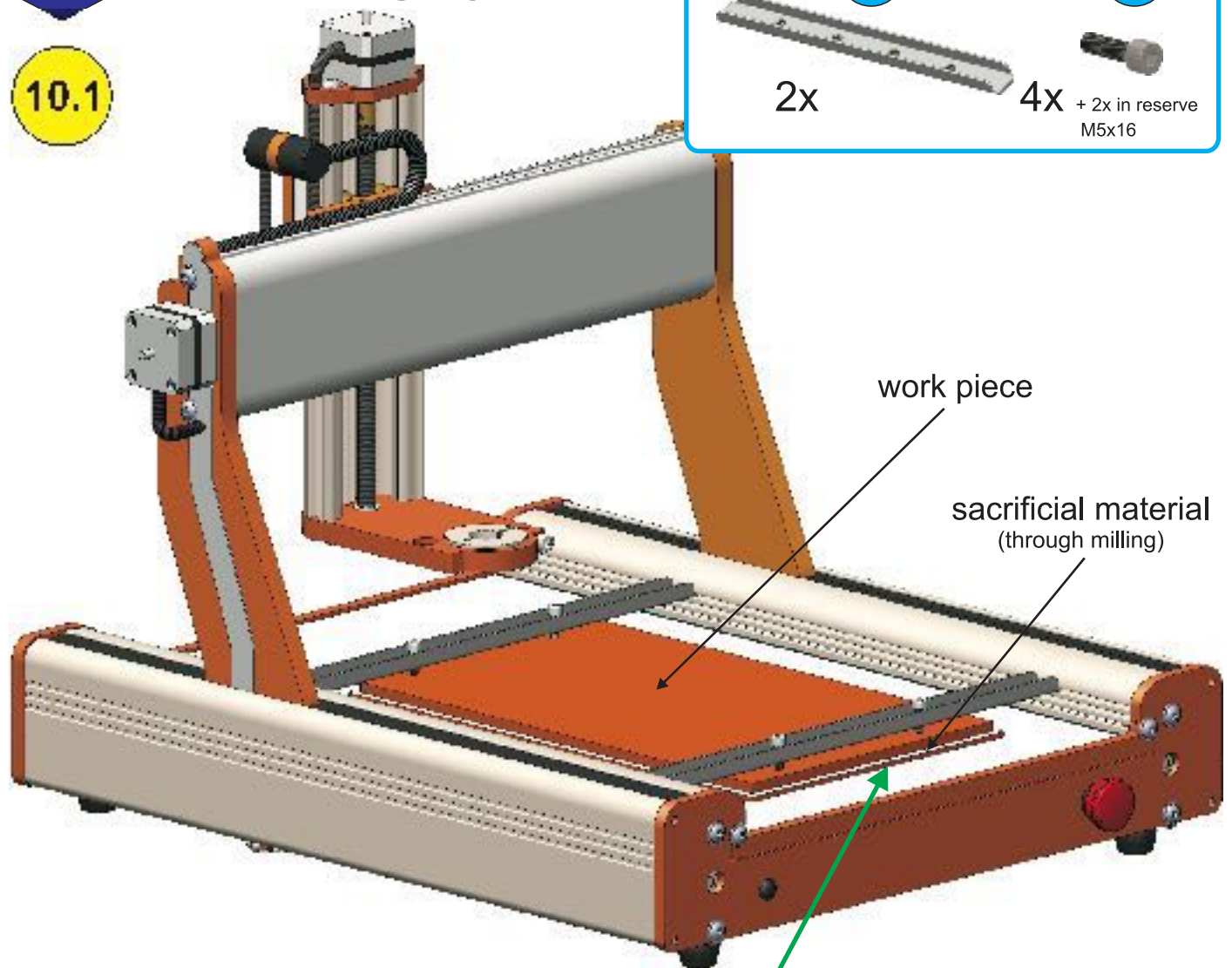
90

2x

38

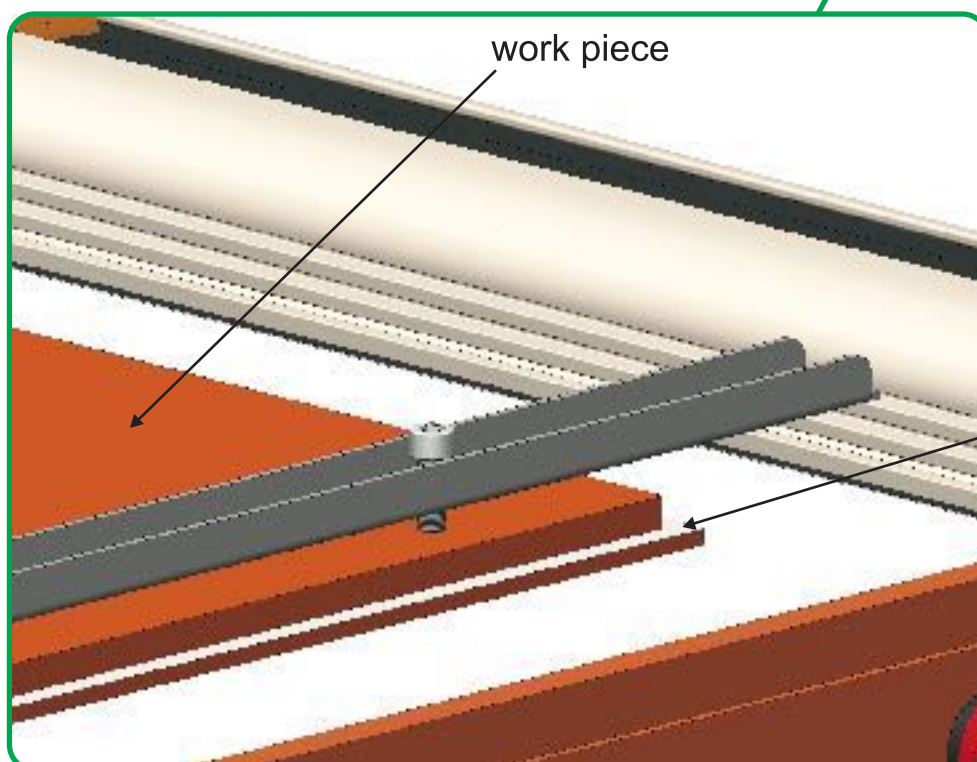
4x

+ 2x in reserve  
M5x16



work piece

sacrificial material  
(through milling)



work piece

sacrificial material  
(through milling)

11

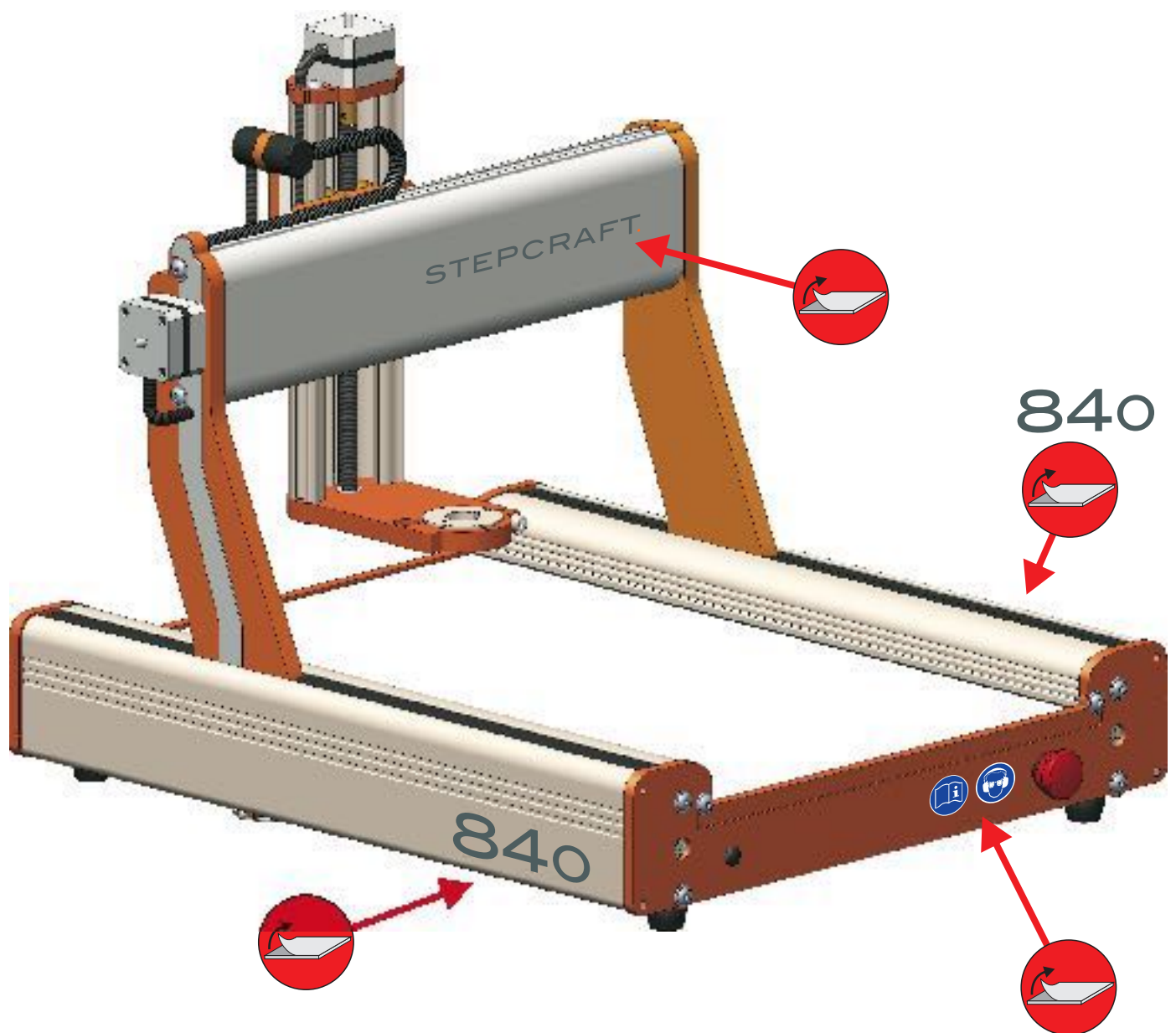
## Label set

11.1

96

label set

1x



12

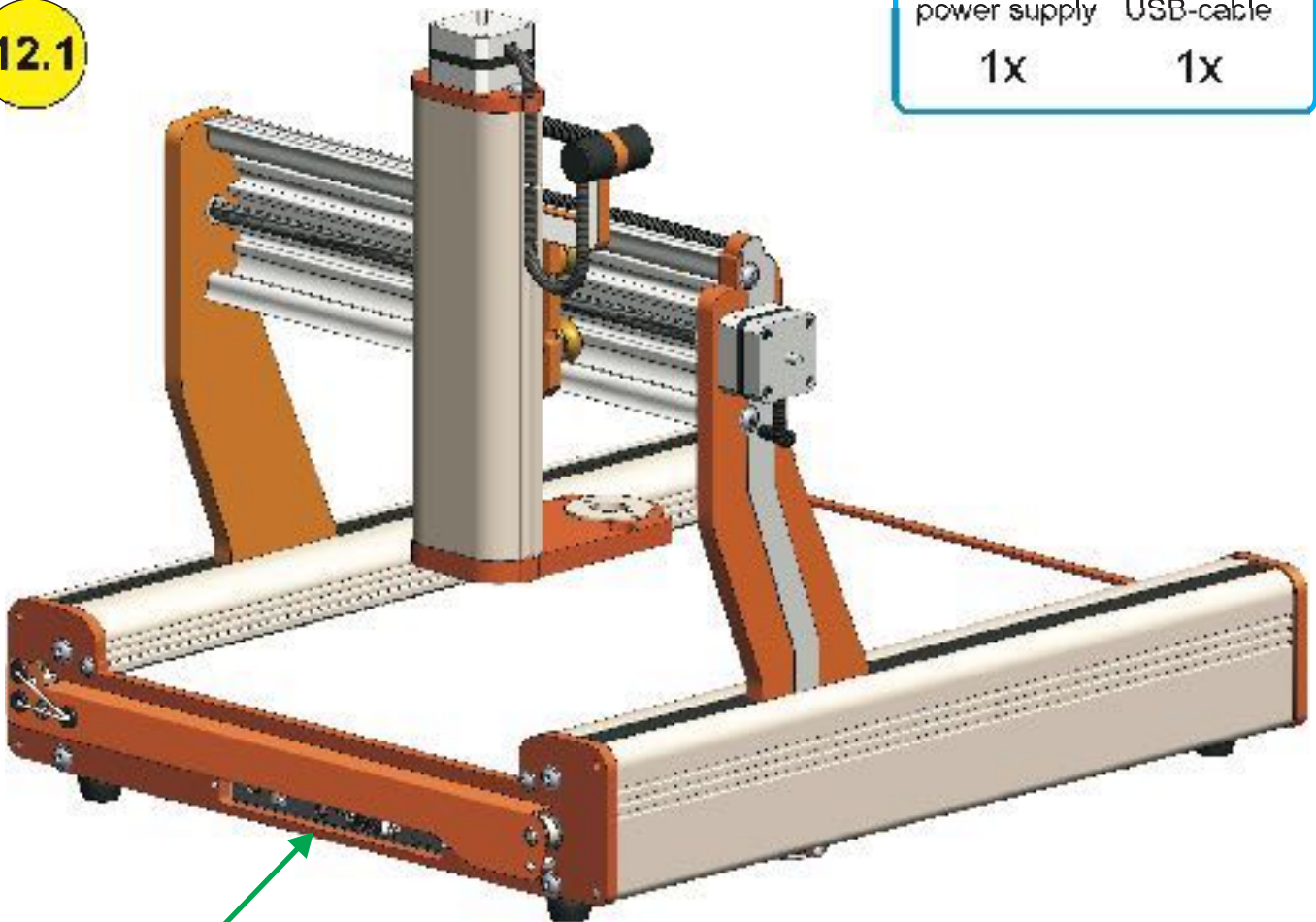
12.1

## Connection of machine with USB module

94

95

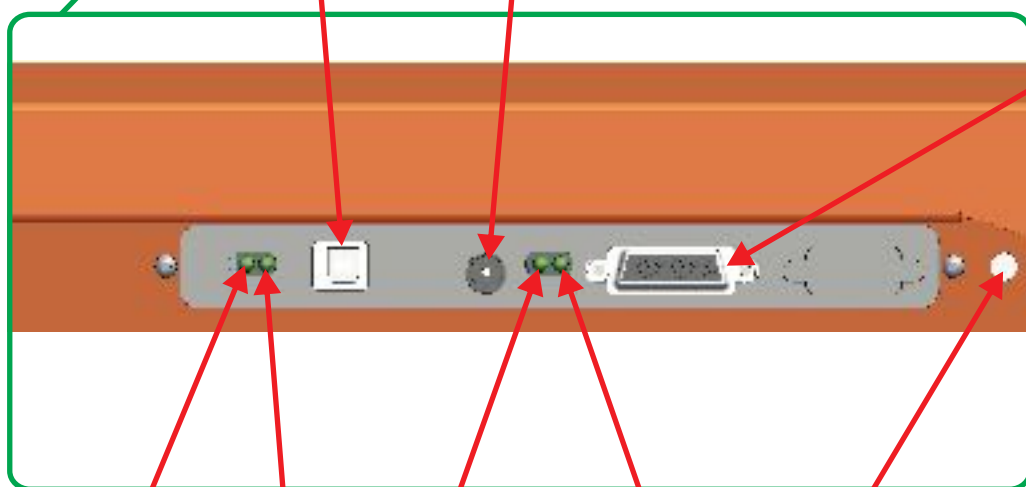
power supply    USB-cable  
1x                    1x



power supply  
DC 30V 3A

USB-interface\*

connector  
for system  
accessories



error USB  
LED

data USB  
LED

power on  
LED

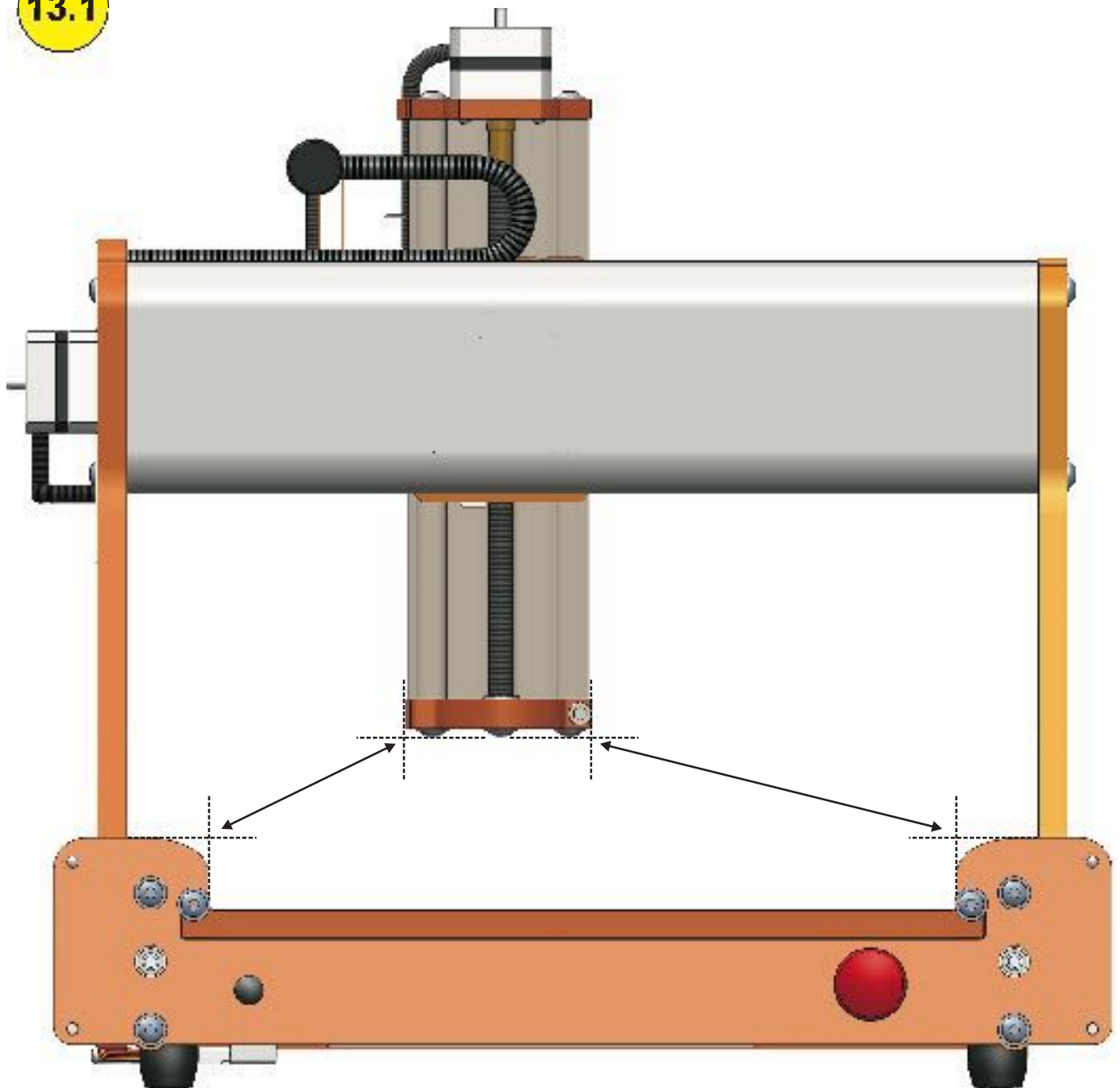
activation (emergency stop)  
LED

notch for tool length  
sensor wire

Signal	Pin
+24V	1
GND	2
+5V/ VCC	3
Direction 4th axis	4
Step 4th axis	5
Relay 2	6
n.a. (Out)	7
Tool length sensor	8
+24V	9
GND	10
Disable	11
Endswitch 4th axis	12
Relay 1	13
Relay 3	14
n.a. (in)	15
PE	shield

**\*Note:** Then using Mach3 or UCCNC the parallel module and an additional USB-parallel-adaptor like UC100 has to be installed instead





For constructional reasons the travel distance of the Z-axis is getting reduced at the end positions of the X-axis by 10 mm.

# Maintenance schedule



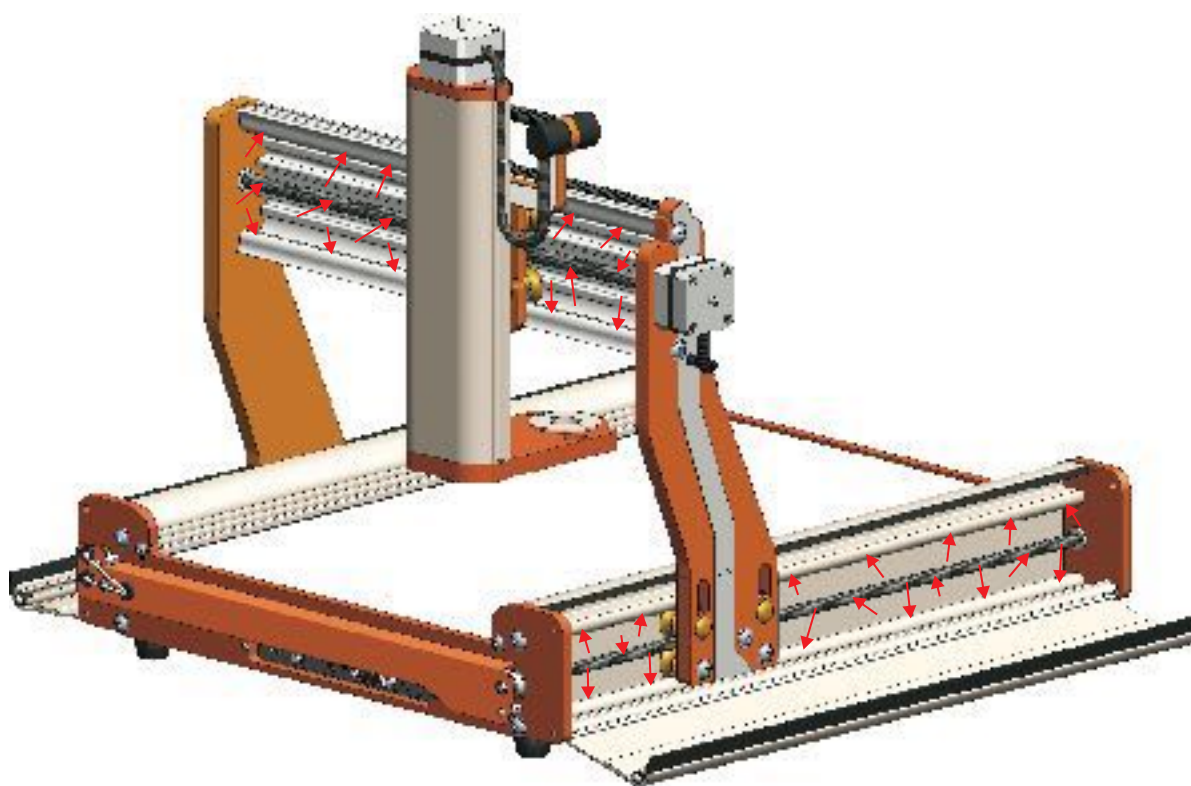
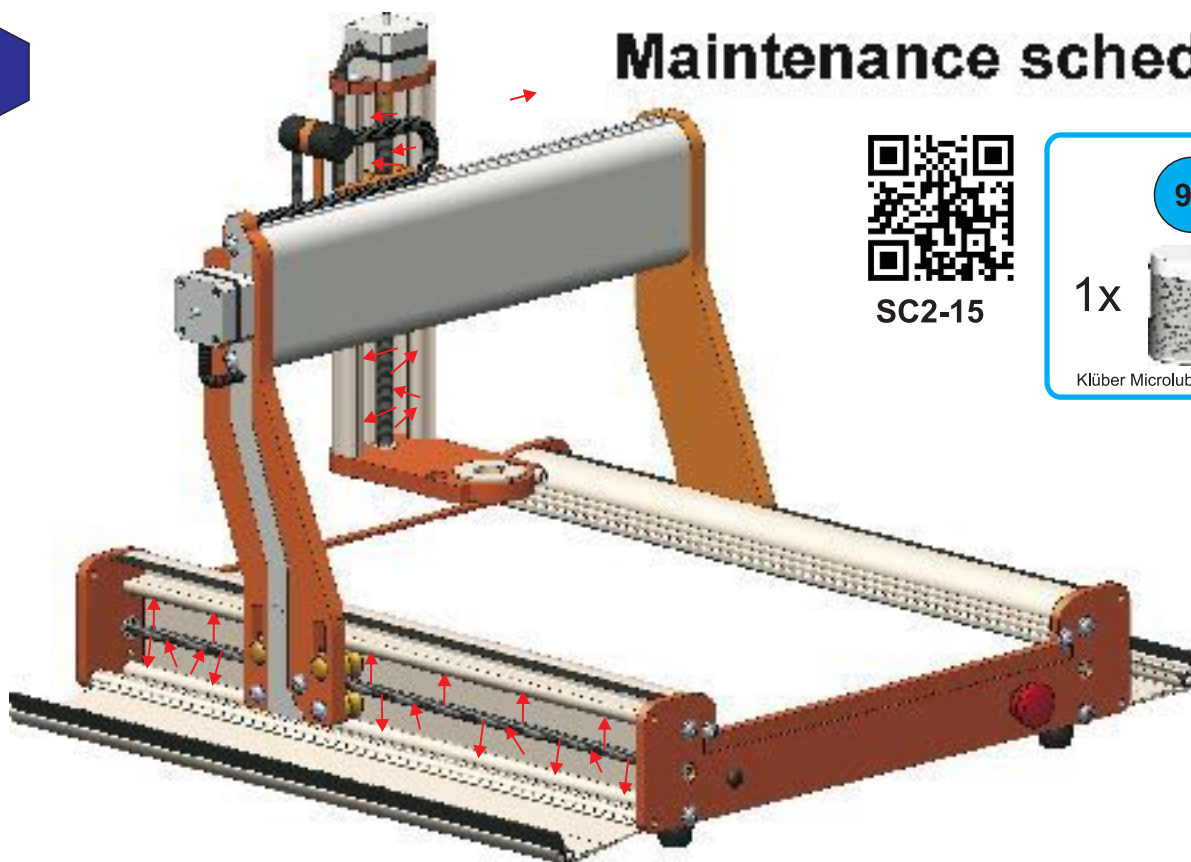
SC2-15

97

1x



Klüber Microlube GL 261



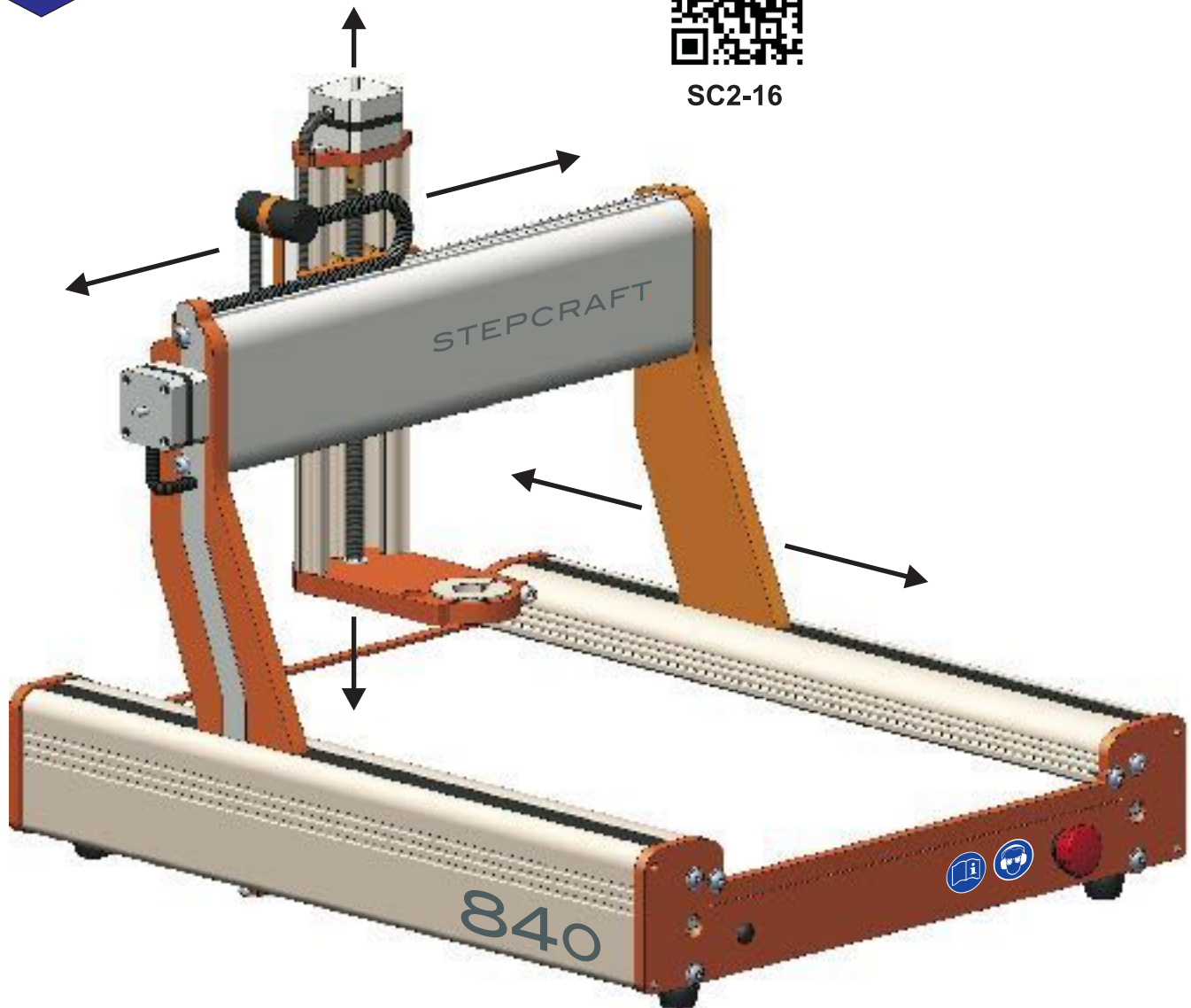
Lubrication of linear tracks and lead screws must be carried out with supplied grease from Stepcraft: *Klüber Microlube GL 261* or other with similar specifications.

**Apply grease on positions marked as mentioned:**

1. All guide areas have to be adequately greased before the machine can be put into service
2. After 20 operating hours wipe the guide area clean and apply grease again
3. Repeat step 2 if soiled but latest every 20 hours



SC2-16



### VERIFICATION OF THE LINEAR AXES

The machine must be noiseless and move without friction and tension in all linear axes. For checking, please proceed as follows:

- Place the machine on a level surface
- First loosen the screws of the gantry parts of the X-axis (see instructions 5.2 and 5.4), the rear (see Instruction 6.5) and the front (see Instruction 8.10) of the Y-axis
- Move the Z-axis manually to an average height
- Move the X-axis manually to each end of the gantry and tighten the screws of each gantry part
- Now move the Y-axis towards the back and tighten the screws of the rear panel firmly
- Lastly proceed now towards the front and tighten the screws on the front panel

**Note:** If you do not reach the final position of an axis in this way, then you must check the smooth running of linear axes and spindles. To do this, close the WinPC-NC or any other CNC control program and unplug the machine from the electricity supply. The X- and Z-axis can then be moved by hand over the axis connector (part 53). For movement of the Y- axis remove the tooth belt cover (part 65), and possibly also the tooth belt (part 63) to check the axes individually.





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