



ROTARY
DRAW BENDERS
RDB-Series



ROTARY DRAW BENDERS

Baileigh Industrial has an extensive line of tube and pipe benders. Whether its manual, hydraulic, or electronically driven machines, Baileigh Industrial's tubing and pipe benders are perfect for round, square, angles, flat bar and much more.

Experience and understanding our customers have led Baileigh to its current lineup of benders. Most of our tubing bender line is manufactured by our sister company right here in Wisconsin, USA. We are one of the largest and most knowledgeable tube bending equipment suppliers in North America and Europe with facilities in both locations.

Manual Benders

The manual tube bender line consists of several machines that can bend up to 2.5" round. The first is the RDB-050, this machine is Baileigh Industrial's answer to the do it yourselfer, but offers several features the competition can't touch. The RDB-100 uses the same tooling as all of our larger machines, if you don't have the budget for a larger hydraulic or programmable machine you can upgrade at a minimal cost.

Hydraulic Benders

The hydraulic pipe bender line consists of five bending machines that either use 110V or 220V, single and three phase 50hz or 60hz to produce perfect bends up to 3" schedule 40 pipe. Large degree dials are on some of the smaller machines but there are also models that allow for programmable bending as well. Several of these models come with foot pedal controls leaving hands free to manipulate the material.

Computer Programmable Benders

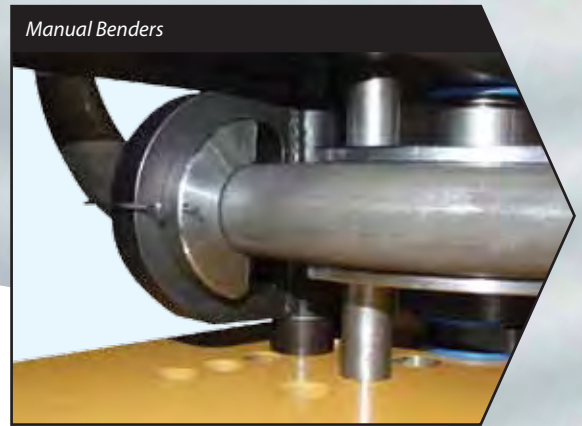
The computer programmable controlled tubing bender line consists of three models that are all a great value. All of the computer programmable machines can be programmed to bend left or right (with proper tooling), as well as bending up to 360° with a universal bend plate. These models can work with many types of square, rounds and rectangles, in varying thicknesses. There are operator control panels and touch screen controls that can hold up to 170 programs. We offer versions that can handle up to a 24" (610 mm) CLR (center line radius) and up to 2-1/2" (73 mm) Schedule 40 (NBP) pipe.

Mandrel Benders

The mandrel bender line consists of machinery that uses heavy duty hydraulics coupled to a simple servo drive system. These NC (numerically controlled) benders are perfect for exhaust, headers, air intakes, turbos, and hand railing applications. Easy touch screen controls – standard.

**BAILEIGH MEANS . . .
PRECISION. PERFORMANCE.
PERFECTION.**

Manual Benders



Hydraulic Benders



Programmable Benders



Mandrel Benders



RDB-050

Economically Priced

The RDB-050 is a manually operated Tube Bender with huge capacity at an economical price.

- ◆ Dies Available for 90 or 180 Degrees
- ◆ Replaceable Bronze Bushings at all pivot points
- ◆ Four Bending Speeds
- ◆ 180 Degree Bends, without repining the die
- ◆ Anti-Spring back mechanism included
- ◆ Integrated Degree Dial Included
- ◆ Quick change hook sleeve inserts, no U-Straps
- ◆ Patent Pending



Specifications		
Mild Steel Pipe (Schedule 40)	Call for Details	Call for Details
Aluminum Pipe (Schedule 40)	Call for Details	Call for Details
Stainless Steel Pipe (Schedule 40)	Call for Details	Call for Details
Mild Steel Round Tube (Wall)	2.50" (.120)	64 mm x 3 mm
Aluminum Round Tube (Wall)	2.50" (.120)	64 mm x 3 mm
Stainless Steel Round Tube (Wall)	2.00" (.120)	50 mm x 3 mm
Chromolly Round Tube (Wall)	2.00" (.120)	50 mm x 3 mm
Mild Steel Solid Rod	1.0"	25 mm
Mild Steel Square Tube (Wall)	N/A	N/A
Minimum OD	.75"	19 mm
Maximum Speed to 180 Degrees	N/A	N/A
Maximum Center Line Radius (CLR)	7.00"	176 mm
Minimum CLR	3.00"	76 mm
Power Requirements	N/A	N/A
Weight (Lbs.)	290	132 kg.
Length	44.00"	1118 mm
Width	27.00"	686 mm
Height	42.00"	1067 mm

Specifications subject to change without notice.

RDB-100

A Real Production Worker

The RDB-100 is a manually operated Tube and Pipe Bender intended for production work.

- ◆ Uses Standard Baileigh Industrial Drop on Die Sets for fast tooling changes
- ◆ Replaceable Bronze Bushings at all pivot points with grease zerks
- ◆ Two Speeds
- ◆ 180 Degree One-Shot bending for lighter materials
- ◆ Anti-Spring back mechanism included
- ◆ Integrated Degree Dial with bend indicator included
- ◆ Stand and Handle included
- ◆ Infinite Tooling possibilities



Specifications		
Mild Steel Pipe (Schedule 40)	1.00"	33.4 mm x 3.4 mm
Aluminum Pipe (Schedule 40)	1.00"	33.4 mm x 3.4 mm
Stainless Steel Pipe (Schedule 40)	.75"	27 mm
Mild Steel Round Tube (Wall)	1.75" (.083)	45 mm x 2 mm
Aluminum Round Tube (Wall)	2.00" (.125)	50 mm x 3 mm
Stainless Steel Round Tube (Wall)	1.50" (.083)	38 mm x 2 mm
Chromolly Round Tube (Wall)	1.50" (.083)	38 mm x 2 mm
Mild Steel Solid Rod	1.00"	25 mm
Mild Steel Square Tube (Wall)	1.00" (.125)	25 mm x 3 mm
Minimum OD	.25"	6 mm
Maximum Speed to 180 Degrees	N/A	N/A
Maximum Center Line Radius (CLR)*	10.50"	267 mm
Minimum CLR	.50"	13 mm
Power Requirements	N/A	N/A
Weight (Lbs.)	290	132 kg.
Length	42.00"	1067 mm
Width	22.00"	560 mm
Height	42.00"	1067 mm

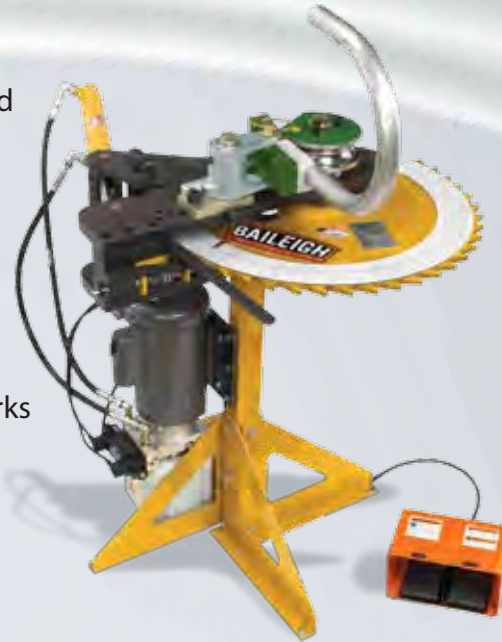
*Maximum CLR dependant on material outside diameter. Specifications subject to change without notice.

RDB-125

For the Budget Minded

Based on our RDB-100, the RDB-125 is the perfect bender for the fabricator that wants a powered bender on a budget.

- ◆ Low Pressure Industrial Grade Hydraulic System
- ◆ Uses Standard Baileigh Industrial Drop on Die Sets for fast tooling changes
- ◆ Replaceable Bronze Bushings at all pivot points with grease zerks
- ◆ Anti-Spring back mechanism included
- ◆ Integrated Degree Dial with bend indicator Included
- ◆ Infinite Tooling possibilities



Specifications		
Mild Steel Pipe (Schedule 40)	2.00"	60 mm x 4 mm
Aluminum Pipe (Schedule 40)	2.00"	60 mm x 4 mm
Stainless Steel Pipe (Schedule 40)	1.50"	48 mm x 3 mm
Mild Steel Round Tube (Wall)	2.50" (.125)	64 mm x 3 mm
Aluminum Round Tube (Wall)	2.50" (.156)	64 mm x 4 mm
Stainless Steel Round Tube (Wall)	2.375" (.125)	60 mm x 3 mm
Chromolly Round Tube (Wall)	2.00" (.125)	50 mm x 3 mm
Mild Steel Solid Rod	1.25"	32 mm
Mild Steel Square Tube (Wall)	2.00" (.125)	50 mm x 3 mm
Minimum OD	.25"	6 mm
Maximum Speed to 180 Degrees	N/A	N/A
Maximum Center Line Radius (CLR)*	10.50"	267 mm
Minimum CLR	.50"	13 mm
Power Requirements	110V	220V, 1Ph, 50Hz
Weight (Lbs.)	350	160 kg.
Length	42.00"	1067 mm
Width	22.00"	560 mm
Height	42.00"	1067 mm

*Maximum CLR dependant on material outside diameter. Specifications subject to change without notice.

RDB-150

For Small to Medium Shops

Available in both auto-stop and non auto-stop versions, the RDB-150 is the perfect tube bender for small to medium fabrication shops.

- ◆ Optional Auto stop for Bend repeatability
- ◆ Bends to 180 degrees in one shot
- ◆ Low Pressure Industrial Grade Hydraulic System
- ◆ Uses Standard Baileigh Industrial Drop on Die Sets for fast tooling changes
- ◆ Replaceable Bronze Bushings at all pivot points with grease zerks
- ◆ Degree Dial with bend indicator Included
- ◆ Infinite Tooling possibilities
- ◆ Portable



Specifications		
Mild Steel Pipe (Schedule 40)	2.00"	60 mm x 4 mm
Aluminum Pipe (Schedule 40)	2.00"	60 mm x 4 mm
Stainless Steel Pipe (Schedule 40)	1.50"	48 mm x 3 mm
Mild Steel Round Tube (Wall)	2.50" (.125)	64 mm x 3 mm
Aluminum Round Tube (Wall)	2.50" (.156)	64 mm x 4 mm
Stainless Steel Round Tube (Wall)	2.375" (.125)	60 mm x 3 mm
Chromolly Round Tube (Wall)	2.00" (.125)	50 mm x 3 mm
Mild Steel Solid Rod	1.25"	32 mm
Mild Steel Square Tube (Wall)	2.00" (.125)	50 mm x 3 mm
Minimum OD	.25"	6 mm
Maximum Speed to 180 Degrees	30 Sec.	30 Sec.
Maximum Center Line Radius (CLR)*	9.50"	241 mm
Minimum CLR	.50"	13 mm
Power Requirements	110V	220V, 1Ph, 50Hz
Weight (Lbs.)	600	272 kg.
Length	44.00"	1118 mm
Width	28.00"	711 mm
Height	42.00"	1067 mm

*Maximum CLR dependant on material outside diameter. Specifications subject to change without notice.

RDB-175

Patented Design

The RDB-175 starts where the RDB-150 left off. Years of experience allowed Baileigh Industrial to improve and add features that customers have been asking for. Features that are so unique the machine is patented.

- ◆ Auto stop for Bend repeatability Included
- ◆ Ratchet Counter die Positioner
- ◆ 2x Faster than standard RDB-150 (12 Seconds to 180 Degrees)
- ◆ Foot pedal operation
- ◆ Bends to 180 Degrees in one shot
- ◆ Low Pressure Industrial Grade Hydraulic System
- ◆ Uses Standard Baileigh Industrial Drop on Die Sets for fast tooling changes
- ◆ Replaceable Bronze Bushings at all pivot points with grease zerks
- ◆ Degree Dial with bend indicator Included
- ◆ Infinite Tooling possibilities
- ◆ Portable ◆ US Patent No. 7,380,430



Specifications		
Mild Steel Pipe (Schedule 40)	2.00"	60 mm x 4 mm
Aluminum Pipe (Schedule 40)	2.00"	60 mm x 4 mm
Stainless Steel Pipe (Schedule 40)	1.50"	48 mm x 3 mm
Mild Steel Round Tube (Wall)	2.50" (.125)	64 mm x 3 mm
Aluminum Round Tube (Wall)	2.50" (.156)	64 mm x 4 mm
Stainless Steel Round Tube (Wall)	2.375" (.125)	60 mm x 3 mm
Chromolly Round Tube (Wall)	2.00" (.125)	50 mm x 3 mm
Mild Steel Solid Rod	1.25"	32 mm
Mild Steel Square Tube (Wall)	2.00" (.125)	50 mm x 3 mm
Minimum OD	.25"	6 mm
Maximum Speed to 180 Degrees	12 Sec.	12 Sec.
Maximum Center Line Radius (CLR)*	9.00"	229 mm
Minimum CLR	.50"	13 mm
Power Requirements	110V	220V, 1Ph, 50Hz
Weight (Lbs.)	630	286 kg.
Length	44.00"	1118 mm
Width	28.00"	711 mm
Height	42.00"	1067 mm

*Maximum CLR dependant on material outside diameter. Specifications subject to change without notice.

RDB-250

More Bang for the Buck

The RDB-250 is the first in Baileigh Industrial's line of Computer Controlled Tube and Pipe Benders. It offers features that only benders double the price have.

- ◆ Computer programmable
- ◆ Programmer holds 170 Jobs with 10 bends per job
- ◆ Can bend 360 Degrees left or right (with optional tooling)
- ◆ Six Bending speeds
- ◆ Fast, 9 Seconds to 180 Degrees
- ◆ 9.0" (229 mm) Maximum Centerline Radius
- ◆ Accepts Optional Positioning table
- ◆ Portable



Specifications		
Mild Steel Pipe (Schedule 40)	2.00"	60 mm x 4 mm
Aluminum Pipe (Schedule 40)	2.00"	60 mm x 4 mm
Stainless Steel Pipe (Schedule 40)	1.50"	48 mm x 3mm
Mild Steel Round Tube (Wall)	2.50" (.125)	64 mm x 3 mm
Aluminum Round Tube (Wall)	2.50" (.156)	64 mm x 4 mm
Stainless Steel Round Tube (Wall)	2.375" (.125)	60 mm x 3 mm
Chromolly Round Tube (Wall)	2.00" (.125)	50 mm x 3 mm
Mild Steel Solid Rod	1.25"	32 mm
Mild Steel Square Tube (Wall)	2.00" (.125)	50 mm x 3 mm
Minimum OD	.25"	6 mm
Maximum Speed to 180 Degrees	9 Sec.	9 Sec.
Maximum Center Line Radius (CLR)*	9.00"	229 mm
Minimum CLR	.50"	13 mm
Power Requirements	220V (1Ph)	220V, 1Ph, 50Hz
Weight (Lbs.)	610	278 kg.
Length	40.00"	1016 mm
Width	32.00"	813 mm
Height	43.00"	1092 mm

*Maximum CLR dependant on material outside diameter. Specifications subject to change without notice.

RDB-325

Our Newest Edition

The RDB-325 is the newest edition to the Baileigh Industrial Tube and Pipe Bender lineup and bridges the gap between the popular RDB-250 and the Workhorse of the line up the RDB-350.

- ◆ Computer programmable
- ◆ Programmer holds 170 Jobs with 10 bends per job
- ◆ Can bend 360 Degrees left or right (with optional tooling)
- ◆ Six Bending speeds
- ◆ Fast, 11 Seconds to 180 Degrees
- ◆ 16.5" (419 mm) Maximum Centerline Radius
- ◆ Accepts Optional Positioning table
- ◆ Portable



Specifications		
Mild Steel Pipe (Schedule 80)	2.00"	60 mm x 5.5 mm
Aluminum Pipe (Schedule 80)	2.50"	73 mm x 5.5 mm
Stainless Steel Pipe (Schedule 40)	2.00"	60 mm x 4 mm
Mild Steel Round Tube (Wall)	3.00" (.095)	76 mm x 2.5 mm
Aluminum Round Tube (Wall)	3.00" (.203)	76 mm x 5 mm
Stainless Steel Round Tube (Wall)	3.00" (.095)	76 mm x 2.5 mm
Chromolly Round Tube (Wall)	3.00" (.083)	76 mm x 2 mm
Mild Steel Solid Rod	1.25"	32 mm
Mild Steel Square Tube (Wall)	2.00" (.125)	50 mm x 3 mm
Minimum OD	.25"	6 mm
Maximum Speed to 180 Degrees	10 Sec.	10 Sec.
Maximum Center Line Radius (CLR)*	16.50"	419 mm
Minimum CLR	.50"	13 mm
Power Requirements	220V (1-Phase)	400V, 3Ph, 50Hz
Weight (Lbs.)	1,200	545 kg.
Length	60.00"	1524 mm
Width	32.00"	813 mm
Height	48.00"	1220 mm

*Maximum CLR dependant on material outside diameter. Specifications subject to change without notice.

RDB-350

A Real Workhorse

The RDB-350 is the workhorse of the Baileigh Industrial line of Tube and Pipe Benders. It will be able to handle almost any job thrown it's way.

- ◆ Computer programmable
- ◆ Easy to use Touch Screen Controls
- ◆ Programmer holds 170 Jobs with 10 bends per job
- ◆ Can bend 360 Degrees left or right (with optional tooling)
- ◆ Quick Release Counter Die System
- ◆ Fast, 16 Seconds to 180 Degrees
- ◆ 24" (610 mm) Maximum Centerline Radius
- ◆ Accepts Optional Positioning table
- ◆ Portable



Specifications		
Mild Steel Pipe (Schedule 40)	2.50"	73 mm x 5 mm
Aluminum Pipe (Schedule 40)	3.00"	89 mm x 5 mm
Stainless Steel Pipe (Schedule 40)	2.00"	60 mm x 4 mm
Mild Steel Round Tube (Wall)	3.00" (.187)	76 mm x 5 mm
Aluminum Round Tube (Wall)	3.50" (.250)	89 mm x 6.5 mm
Stainless Steel Round Tube (Wall)	3.00" (.125)	76 mm x 3 mm
Chromolly Round Tube (Wall)	2.50" (.125)	64 mm x 3 mm
Mild Steel Solid Rod	1.50"	38 mm
Mild Steel Square Tube (Wall)	3.00" (.125)	76 mm x 3 mm
Minimum OD	.24"	6 mm
Maximum Speed to 180 Degrees	16 Sec.	16 Sec.
Maximum Center Line Radius (CLR)*	24.00"	610 mm
Minimum CLR	.50"	13 mm
Power Requirements	220V (3Ph)	400V, 3Ph, 50Hz
Weight (Lbs.)	1500	681 kg.
Length	69.00"	1753 mm
Width	32.00"	813 mm
Height	46.00"	1168 mm

*Maximum CLR dependant on material outside diameter. Specifications subject to change without notice.

RDB-500

Enormous Capacity

The RDB-500 is truly a monster when it comes to capacity. Three inch Schedule 40 Pipe is no match for this Hydraulic Tube and Pipe Bender.

- ◆ Auto Stop for Bend repeatability included
- ◆ Bends to 180 degrees in one shot
- ◆ Low Pressure Industrial Grade Hydraulic System
- ◆ Uses Standard Baileigh Industrial Drop on Die Sets for fast tooling changes
- ◆ Replaceable Bronze Bushings at all pivot points with grease zerks
- ◆ Infinite Tooling possibilities
- ◆ Portable



Specifications		
Mild Steel Pipe (Schedule 40)	3.00"	89 mm x 5.5 mm
Aluminum Pipe (Schedule 40)	3.50"	102 mm x 6 mm
Stainless Steel Pipe (Schedule 40)	2.50"	73 mm x 5 mm
Mild Steel Round Tube (Wall)	3.00" (.250)	76 mm x 6.5 mm
Aluminum Round Tube (Wall)	3.50" (.250)	89 mm x 6.6 mm
Stainless Steel Round Tube (Wall)	3.50" (.187)	89 mm x 5 mm
Chromolly Round Tube (Wall)	3.50" (.187)	89 mm x 5 mm
Mild Steel Solid Rod	2.00"	50 mm
Mild Steel Square Tube (Wall)	3.00" (.250)	76 mm x 6.5 mm
Minimum OD	.25"	6 mm
Maximum Speed to 180 Degrees	36 Sec.	36 Sec.
Maximum Center Line Radius (CLR)*	20.00"	508 mm
Minimum CLR	.50"	13 mm
Power Requirements	220V (3Ph)	400V, 3Ph, 50Hz
Weight (Lbs.)	1800	820 kg.
Length	70.00"	1778 mm
Width	56.00"	1422 mm
Height	41.00"	1041 mm

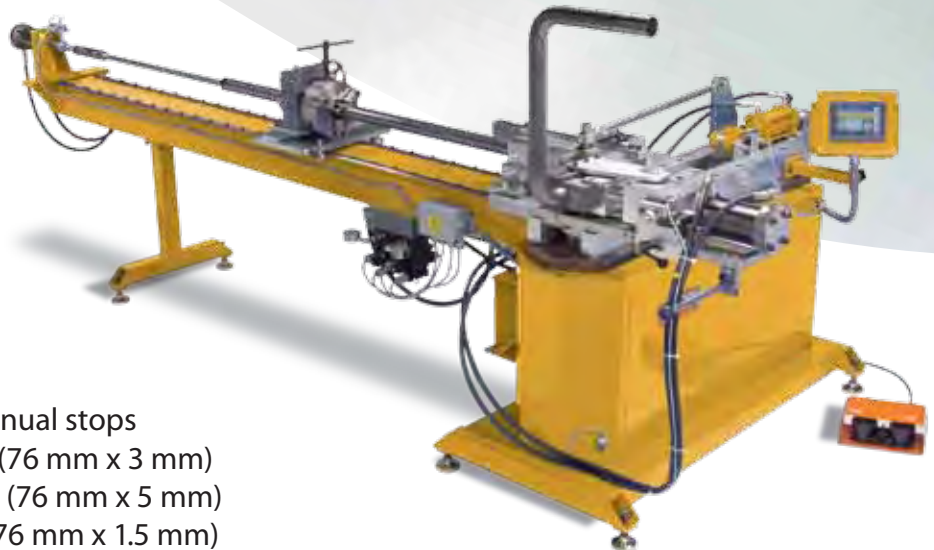
*Maximum CLR dependant on material outside diameter. Specifications subject to change without notice.

MB-350

The Ultimate Mandrel Bender

The MB-350 Mandrel Bender is the perfect machine for bending tight radii (down to 1-1/2 times the OD) of round tube and pipe, as well as square tubing.

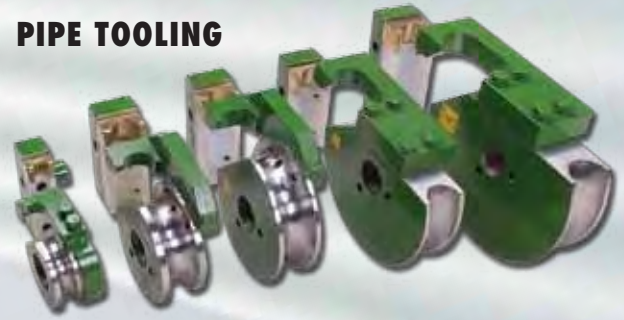
- ◆ Computer Programmable
- ◆ Easy to Use Touch Screen Controls
- ◆ Programmer holds 140 Jobs with 10 bends per job
- ◆ Fast, 16 seconds to 180 degrees
- ◆ 10 foot Extraction Table
- ◆ Rotary positioning carriage with 4 manual stops
- ◆ Round Mild Steel – 3" OD x .125" Wall (76 mm x 3 mm)
- ◆ Round Aluminum – 3" OD x .188" Wall (76 mm x 5 mm)
- ◆ Round Stainless – 3" OD x .065" Wall (76 mm x 1.5 mm)
- ◆ Square Mild Steel – 2" x 2" x .188" OD (50 mm x 50 mm x 5 mm)
- ◆ Solid Bar Mild Steel – 1.181" OD (30 mm)



Tooling and Accessories

HUNDREDS OF SIZES AVAILABLE.
 These are some of the common die packages with separate part numbers for your convenience. To ensure proper tooling for your application, consult a Baileigh representative. All pipe packages based on Schedule 40 pipe.

PIPE TOOLING



TUBE TOOLING



RT-1B – Round Tubing Die Package			
DS-0750T-R250	3/4" Round Tube Die Set	.058 Min. Wall	2.5" clr
DS-0875T-R300	7/8" Round Tube Die Set	.058 Min. Wall	3.0" clr
DS-1000T-R300	1" Round Tube Die Set	.063 Min. Wall	3.0" clr
DS-1250T-R400	1-1/4" Round Tube Die Set	.083 Min. Wall	3.0" clr
DS-1500T-R500	1-1/2" Round Tube Die Set	.083 Min. Wall	5.0" clr

RT-2B – Round Tubing Die Package			
DS-0750T-R250	3/4" Round Tube Die Set	.058 Min. Wall	2.5" clr
DS-0875T-R300	7/8" Round Tube Die Set	.058 Min. Wall	3.0" clr
DS-1000T-R300	1" Round Tube Die Set	.063 Min. Wall	3.0" clr
DS-1250T-R400	1-1/4" Round Tube Die Set	.083 Min. Wall	4.0" clr
DS-1500T-R500	1-1/2" Round Tube Die Set	.083 Min. Wall	5.0" clr
DS-2000T-R700	2" Round Tube Die Set	.109 Min. Wall	7.0" clr

RT-3B – Round Tubing Die Package			
DS-1000T-R300	1" Round Tube Die Set	.063 Min. Wall	3.0" clr
DS-1250T-R400	1-1/4" Round Tube Die Set	.083 Min. Wall	4.0" clr
DS-1500T-R500	1-1/2" Round Tube Die Set	.083 Min. Wall	5.0" clr
DS-1625T-R600	1-5/8" Round Tube Die Set	.083 Min. Wall	6.0" clr
DS-1750T-R700	1-3/4" Round Tube Die Set	.083 Min. Wall	7.0" clr

RP-1B – Round Pipe Die Package (NBP)			
DS-0500P-R250	1/2" Round Pipe Die Set	.840" OD	2.5" clr
DS-0750P-R300	3/4" Round Pipe Die Set	1.050" OD	3.0" clr
DS-1000P-R300	1" Round Pipe Die Set	1.315" OD	3.0" clr
DS-1250P-R400	1-1/4" Round Pipe Die Set	1.660" OD	4.0" clr
DS-1500P-R500	1-1/2" Round Pipe Die Set	1.900" OD	5.0" clr

RP-2B – Round Pipe Die Package (NBP)			
DS-0500P-R250	1/2" Round Pipe Die Set	.840" OD	2.5" clr
DS-0750P-R300	3/4" Round Pipe Die Set	1.050" OD	3.0" clr
DS-1000P-R300	1" Round Pipe Die Set	1.315" OD	3.0" clr
DS-1250P-R400	1-1/4" Round Pipe Die Set	1.660" OD	4.0" clr
DS-1500P-R500	1-1/2" Round Pipe Die Set	1.900" OD	5.0" clr
DS-2000P-R600	2" Round Pipe Die Set	2.375" OD	6.0" clr

RP-3B – Round Pipe Die Package (NBP)			
DS-1250P-R300	1-1/4" Round Pipe Die Set	1.660" OD	3.0" clr
DS-1500P-R375	1-1/2" Round Pipe Die Set	1.900" OD	3.75" clr

ST-1B – Square Tube Die Package			
DS-0500S-R300	1/2" Square Tube Die Set	.035 Min. Wall	3.0" clr
DS-0750S-R350	3/4" Square Tube Die Set	.035 Min. Wall	3.5" clr
DS-1000S-R450	1" Square Tube Die Set	.049 Min. Wall	4.5" clr
DS-1250S-R550	1-1/4" Square Tube Die Set	.063 Min. Wall	5.5" clr
DS-1500S-R650	1-1/2" Square Tube Die Set	.083 Min. Wall	6.5" clr

ST-2B – Square Tube Die Package			
DS-0500S-R300	1/2" Square Tube Die Set	.035 Min. Wall	3.0" clr
DS-0750S-R350	3/4" Square Tube Die Set	.035 Min. Wall	3.5" clr
DS-1000S-R450	1" Square Tube Die Set	.049 Min. Wall	4.5" clr
DS-1250S-R550	1-1/4" Square Tube Die Set	.063 Min. Wall	5.5" clr
DS-1500S-R650	1-1/2" Square Tube Die Set	.083 Min. Wall	6.5" clr
DS-2000S-R700	2" Square Tube Die Set	.120 Min. Wall	7.0" clr

Optional – Rotary Positioning Tables



Optional – Universal Bend Plate



Optional – Angle Finder



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