



Innovators & Manufacturers
of Precision Forestry Equipment

Griffiths & Beerens



Chainsaw Guide **Bar & Sprocket Manual**



Chainsaw Guide Bar & Sprocket Manual

This sales manual will help you understand the outstanding features of GB bars & sprockets.

This manual contains the features and benefits of the guide bars and sprockets that GB manufacture and explains the procedures and methods used to produce the highest quality products available in our industry.

This manual will assist you and your sales team in selling GB products.

It shows you how GB guide bars and sprockets are superior to any of their competition and will help you sell the product with greater confidence.

It will also allow you to instil more confidence in your customers and let your customers realise the quality and satisfaction they will gain out of selling a GB product.





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PROFESSIONAL HARD-TOP



It may be descended from the original guide bar concept, but this solid-nose work-horse is still in demand.

The Professional Hard-Top has been thoroughly field tested in the world's toughest hardwood forests. As a result, GB's researchers and technicians have created an incredibly durable hard-nose bar that wins respect from any professional logger.

Tough cutting situations, such as land clearing, stump removal, salvage operations, demolition, etc. call for tough cutting attachments. And, the GB Hard-Top bar is as tough as they come. This high-quality, solid-nose bar is built to withstand the most abusive and abrasive conditions.

The Hard-Top is crafted from solid T-40 steel--a high-tech alloy specified by GB engineers, who work closely with industrial metallurgist to isolate the ideal alloys for various GB guide bar applications.

Furthermore, GB has enhanced the Hard-Top with a brand new hard-facing alloy used in the space industry--NASALLOY 8. A generous deposit of this material is fused to the nose radius. Its fierce resistance to heat and wear guarantee extended life and assure customer satisfaction.

SPECIFICATIONS:

- Lengths:** 10" - 44"
- Groove:** .050", .058", .063"
- Pitch:** All
- Nose:** Six nose radii sizes available



Professional Hard Top is ideal for tough abusive conditions.



PROFESSIONAL HARD-TOP

FEATURES

- One-piece, solid, high-carbon steel body (GB T-40 alloy).
- Laser-cut for precision shape and fit-up.
- New NASALLOY 8 hard facing material extends well beyond nose radius, into transition zone where chain slap erodes rails of ordinary bars.
- Nose radius has been engineered for maximum performance & durability.
- Grooves are individually precision-ground, not mass-milled. This places the groove dead centre & unlike milling, creates much smoother rails.
- Ground grooves have rounded gullets for more strength.
- Rails are uniformly induction hardened and tempered.
- Excellent hardness, straightness, durability and overall life.
- Audited for quality and fully guaranteed.

BENEFITS:

- Less friction in rails / strengthened base of each rail.
- Maximum chain and bar life.
- Superior resistance to wear.
- Superior resistance to rail chipping.
- Cutting performance enhanced.
- Consistent groove width.
- Minimizes bar wear in abusive or abrasive conditions and improves performance.
- Strength and resilience.
- New hard-facing alloy, NASALLOY 8, exceeds performance of other materials.

GB...more than just bars.



PROFESSIONAL PRO-TOP



GB Pro-Top is a durable replaceable sprocket nose bar designed and built for demanding professional users. Like other GB professional-use bars, the Pro-Top is ideally suited for high-speed / high-powered chainsaws where light weight and extreme durability are required. Pro-Top bars are precision engineered from high-tech, lightweight alloy steel for extra-long life and easy maneuverability.

The Pro-Top's sprocket nose assembly supports the saw chain as it rounds the nose. This reduces friction, allowing greater chain tension and up to 25% more cutting power compared to professional hard nose bars. These wear-reducing attributes allow a considerably narrower nose profile, making the Pro-Top especially well-suited for boring and/or limbing applications.

The time-tested Pro-Top nose cartridge is incredibly strong, with titanium alloy steel side-plates, precision Swiss bearings, specially-hardened sprocket and unique self-locking feature. During hardening, the nose side plates are injected with Carbon Nitride, which guarantees that Pro-Top is the hardest-wearing replaceable sprocket nose in the world.

Its body is equally tough. Pro-Top is crafted from a solid, high-carbon steel alloy that is specially heat-treated and tempered for super-long life. Its rails are extraordinarily strong, thanks to GB's precision groove-grinding process, and very resistant to wear and breakage as a result of induction hardening. The result is flawless, pro quality performance--cut after cut.

SPECIFICATIONS:

Lengths: 16" - 44"

Groove: .050", .058", .063"

Pitch: .325" - 12-tooth standard nose;
3/8" - 11-tooth standard nose



Pro-Top bar is designed for professional loggers & delivers maximum performance under the most demanding conditions



PROFESSIONAL PRO-TOP

FEATURES:

- One-piece solid steel body; specially heat-treated and tempered for high strength.
- Laser-cut for precision shape and fit-up.
- Precision-ground grooves.
- Rails are induction hardened and tempered.
- Super-tough, high-tech alloy sprocket glides on precision Swiss bearings.
- Nose cartridge side plates made of titanium alloy steel, hardened to CN40 specifications.
- Nose self-locks over a solid steel web on the bar body. Held firmly together by three high- tensile rivets.
- All GB bars are fully inspected and subjected to a strict quality assurance system during manufacturing.

BENEFITS:

- Superior resistance to wear.
- Tougher and stronger nose plates can withstand greater abuse than those on competitive bars.
- Easy nose replacement.
- Precision shape and fit-up.
- Uniform rails with a strong base radius.
- Cutting performance enhanced.
- Maximum chain and bar life.
- More forgiving in cutting mishaps. Nose can usually be straightened and reused. Competitive noses may break or cause damage to bar body.
- Less chain-throwing and, thus, less risk of damage to the bar groove and rails.
- Extremely tough and durable.

GB...committed to quality.



PROFESSIONAL VQ .404" PRO-TOP



A new generation of heavy-duty, .404" pitch professional guide bars has been developed for professional cutters who demand exceptional performance and life. The GB .404" pitch Pro-Top was developed with the cooperation of field-test crews working under varied timber conditions. GB development engineers analyzed this reliable feedback, comparing and confirming the bar's impressive laboratory results with those encountered under tough field conditions.

The resulting .404" pitch Pro-Top represents a completely new design concept. The body profile has been widened and the nose cartridge fortified with the new VQ, 11-tooth harvester bar sprocket. This rugged sprocket was designed to withstand the excessive forces of mechanical harvesting. It is made of tough, titanium alloy steel-the same alloy used in GB harvester bars. This extra measure of quality guarantees the highest performance and durability, and assures that the GB .404-in. pitch Pro-Top is the finest sprocket nose bar available today. Harvester bar quality in a chainsaw bar body!

SPECIFICATIONS:

Length:	20"- 44"
Groove:	.058", .063"
Pitch:	.404"
Nose:	11-tooth



The VQ .404" pitch RSN bar features a harvester sprocket and a NEW, wider profile body for superior strength versus the competition



PROFESSIONAL VQ .404" PRO-TOP

FEATURES:

- One-piece solid body bar with wider profile.
- Extra strong 11 tooth Sprocket, has more "MEAT" at the sprocket gullet.
- High-tech alloy steel construction with increased resilience and resistance to bending.
- Induction hardened, precision-ground rails.
- Advanced sprocket geometry that minimizes chain outlet contact loads and maximizes sprocket strength.
- Nose cartridge manufactured to exacting tolerances to maintain precision clearances for sprocket rotation.
- High tensile alloy rivet system.
- Precision-ground Swiss bearings lubricated with special high-temperature, high-adherence grease.
- Fully guaranteed.

BENEFITS:

- Outstanding reliability and added durability.
- Superior materials make bar body much more resilient.
- Long rail life with minimal risk of chipping or rail spreading.
- Smooth chain transport from nose sprocket to bar.
- Rugged, dependable.
- Less chance of breaking sprocket or sprocket teeth.
- Less frictional heating of sprocket/bearing/hub assembly.
- Longer bearing life.
- Resistance to nose spreading.
- Sprocket nose cartridge easy to replace.

GB...over 45 years in the industry.



CN40 TITANIUM PRO-TOP



A revolutionary break through in professional chainsaw bars has been made. Amazingly GB have taken a harvester bar in a chainsaw bar body. Through extensive research & development, not only in the field but also in our manufacturing process, GB have developed the only professional TITANIUM sprocket nose chainsaw bar in the world. Manufactured from CN40 Titanium alloy steel and injected with Carbon Nitride Gas, the new CN40 titanium pro-top will allow for far more flexibility in the bar body than any of our competitor's professional bars and guarantees rail strength far superior to any chainsaw bar in the world. The rail strength comes from our precision groove grinding process, which allows us to grind exact precise rails through the most demanding Titanium steel. Its ultra lightweight allows for easy manoeuvrability and longer hours in day-to-day operations.

The CN40 Titanium pro-top is assembled with our pro-top replaceable sprocket nose. Already considered the best replaceable sprocket nose in the world and also manufactured from Titanium alloy steel, GB's replaceable sprocket nose is fitted up with a precision Swiss bearing and has a unique self locking system. For added nose strength we inject the nose side plates with Carbon Nitride, which increases wearing properties and absolutely guarantees the hardest wearing replaceable sprocket nose in the world.

The CN40 Titanium pro-top is ideally suited for high powered/ high-speed chainsaws where extreme durability is placed on the chainsaw bar.

Tested by varied professional loggers from Australia and America, the results have been nothing but outstanding and GB can guarantee that its **New** CN40 Titanium Pro-Top bar will outlast any competitors professional bar in the world by twice its life. The Revolution that is taking over the professional chainsaw bar market today.

SPECIFICATIONS:

Length: 18" - 36"

Groove: .050", .058", .063"

Pitch: 3/8"

Nose: 11 tooth



CN40 TITANIUM PRO-TOP

FEATURES:

- One-piece Titanium steel body.
- Laser cut for precision shape & fit up.
- Precision ground grooves.
- Rails are injected with carbon nitride.
- Super-tough, high-tech alloy sprocket glides on precision Swiss bearings.
- Nose cartridge side plates made of Titanium alloy steel, hardened to CN40 specifications.
- Nose self locks over a solid steel web on bar body, held firmly together by three high tensile rivets.

BENEFITS:

- Much more flexibility in bar body.
- Hardest wearing rails in the world. Strongest bar in the world.
- More life than any other Professional chainsaw bar in the world.
- Light weight. Easy Manoeuvrability.
- Precision shape & fit up.
- Uniform rails with a strong base radius.
- Cutting performance enhanced
- Maximum chain & bar life.
- More forgiving in cutting mishaps. Nose can usually be straightened & reused. Competitive noses may break or cause damage to bar body.
- Less chain throwing therefore less risk of damage to the bar groove and rails.

GB...precision engineers.



POWER-TECH



Why install a cheap laminated guide bar when you can mount a quality, solid steel Power- Tech bar for the same money?

PowerTech, the latest breakthrough from GB, is a slim-contour, one-piece, sprocket nose guide bar. Manufactured from the same high-tech alloy steel as GB professional bars, only 1/16" thinner. The Power-Tech bar offers pro-quality features and performance, yet weighs no more than a laminated bar--an ideal choice for professional woodcutters or discriminating casual users.

PowerTech bars are more durable & stronger than Laminated bars.

SPECIFICATIONS:

Length: 12" - 20"

Groove: .050", .058", .063"

Pitch/Tooth Count: .325"/11, 3/8"/10, 3/8" LP/9



Power-Tech bar is preferred by professional arborist for its light weight and easy maneuvering



POWER-TECH

FEATURES:

- One-piece steel construction--no welds!
- Laser-cut for precision shape and fit-up.
- Precision-ground grooves assure uniform rail thickness and a strong radius at the base of the rail.
- Rails are induction-hardened and tempered.
- Steel bar body is tempered for strength.
- Professional sprocket glides on precision Swiss bearings.
- Sprocket is replaceable.
- Fully guaranteed.

BENEFITS:

- Attractively priced--save money!
- Weighs the same as a laminated guide bar.
- Improved maneuverability.
- Superior resistance to wear; extremely durable.
- Greater strength in bar body.
- Maximum bar life and greater value.
- Won't bend like a laminated bar; no spot-welds to break.
- Consistent groove width, less friction.
- Cutting performance enhanced.

GB...proud of our history, excited about our future.



POWER-TECH ARBOR



By popular demand, GB has applied its Power-Tech concept to a new range of arborist bar sprocket nose. This is a true professional, solid, one-piece sprocket nose bar. Available in .325" x 10 teeth & 3/8"LP x 9 teeth

SPECIFICATIONS:

- Length:** 12" - 20"
Groove: .050"
Nose: .325" x 10T, 3/8"LP x 9T

FEATURES:

- Smaller nose radius.
- Solid one-piece bar made from high-tech alloy steel.
- Induction-hardened, precision-ground rails.
- Sprocket glides on precision Swiss bearings.
- No spot welds!

BENEFITS:

- Low kick-back.
- Light weight.
- Superior resistance to wear.
- Stronger body than laminated bars.
- Professional quality.

A PROFESSIONAL BAR - SOLID NOT LAMINATED

GB...most extensive range, World wide.



POWER-TECH MINI



By popular demand, GB has applied its Power-Tech concept to a new range of reduced nose-radius bars with low-kick, 7-tooth 3/8" LP sprocket nose. This is a true professional, low-kick, solid, one-piece sprocket nose bar.

SPECIFICATIONS:

Length:	12" - 18"
Groove:	.050", .043"
Pitch:	3/8" LP
Nose:	7-Tooth

FEATURES:

- Smaller nose radius.
- Solid one-piece bar made from high-tech alloy steel.
- Induction-hardened, precision-ground rails.
- Sprocket glides on precision Swiss bearings.
- No spot welds!

BENEFITS:

- Low kick-back.
- Light weight.
- Superior resistance to wear.
- Stronger body than laminated bars.
- Professional quality.

GB...Customer focused.



MINI-CUT POWER TIP



The Mini-Cut Power Tip is an economical, laminated consumer bar with built-in sprocket nose for faster cutting. It has more welds than ordinary laminated bars, giving it extra strength and longer life.

SPECIFICATIONS:

- Length:** 12" - 18"
Groove: .050" and .043"
Pitch: 3/8" LP
Nose: 9-Tooth

FEATURES:

- Laminated construction with a slim contour.
- Smaller nose radius.
- Alloy-steel construction with deep heat-treated bar rails.

BENEFITS:

- Less weight and bulk.
- Improved maneuverability.
- Reduced kick-back.
- Suits most cutting conditions.



EXTRA LONG



GB is one of the only manufacturers in the world capable of producing extra-long bars and variations made for special applications, such as chainsaw mills.

GB extra-long bars are crafted from solid, high-tech titanium alloy steel with precision-ground grooves--by far, the toughest, most durable extra-long chainsaw bar in the world.

These extra long bars are fitted with GB's new, Super Tough RQ/RA replaceable sprocket nose cartridge, which was originally developed for mechanical harvesting applications. The New nose system is easily replaced in the shop or on the job.

The New RQ/RA replaceable sprocket nose is manufactured from Hi-Tech Titanium alloy steel and is put through GB's exclusive CN40 hardening process. The end result is a far more stronger and durable nose system that will guarantee maximum wear and extended life.

Another advantage is the New 5 rivet lock connection. With all rivets pre-hardened, GB guarantee maximum strength and less breakage. The 5 rivet lock connection is fitted to precision milled webbing of the bar for a perfect connection.

The extended nose rails are also a New feature which will give longer nose wear and extra bar life as noses are able to take more stress and reduce wear on bar rails.

All GB Extra Long Bars come fitted with the RQ (.404") nose. The RA (3/8") nose is an optional replaceable nose that will be sold separately.



GB leads the world in extra-long bar selection, quality & performance



EXTRA LONG

SPECIFICATIONS:

Lengths: 44" - 87"

Groove: .063"

Pitch: .3/8" (RA), .404" (RQ)

Nose: 3/8" = 11 tooth, .404" = 11 tooth

FEATURES:

- Made from Hi Tech Titanium Alloy Steel.
- Precision-ground grooves.
- Extra strong bending properties.
- Can be re-grooved for extra-long life.
- Replaceable sprocket nose.
- Premium Swiss roller bearings.
- Bar rails are true and give longer life because they are made from hardened titanium steel.
- Hardened rivets.
- Extended nose rails.
- Super strong 5 rivet nose connection.
- Precision milled webbing.

BENEFITS

- Easy replaceable nose.
- Minimal bending/ bowing in bar.
- Long rail and bar life.
- Rail chipping and spreading are minimized.
- Hi-tech materials used to make bar body much more resilient.
- Cutting performance enhanced.
- Less chain throwing.
- More economical.
- Special extra long bars made on request.



HI-TECH DOUBLE ENDER



The GB Mill and Deck bar is now setting the standard for the world to follow. Due to our unique manufacturing facilities, GB is able to make double-ended bars ranging from 44" to 87". Made from Hi-Tech Titanium alloy steel, GB guarantee the strongest, most durable double ended bar. The bars have precision ground grooves and even rails to give maximum performance time and time again.

GB Double-ended bars are designed with a universal mount to suit all pro saws.

SPECIFICATIONS:

Lengths:	44" - 87"
Groove:	.063"
Pitch:	All
Nose:	None

FEATURES:

- Bar body crafted in solid, high-tech titanium alloy steel.
- Precision-ground grooves; Uniform, induction-hardened rails.
- Bar can be re-grooved for extra-long life.
- Can be operated with 2 power heads.
- Laser-cut for precision shape and fit up.
- Excellent hardness, straightness, durability and overall life.
- Audited for quality and fully 100% guaranteed.

BENEFITS

- Super-resilient--minimal bending/ bowing, even with longer lengths.
- Extended rail and bar life.
- Cutting performance enhanced.
- Consistent groove width.
- Superior resistance to rail chipping.

GB...continuing to grow.



TITANIUM CARVING



GB carving bars are designed with a slender body and extremely small nose radius, for ultra-precise wood shaping and sculpting. Made from solid titanium alloy steel, they are very light weight and easy to maneuver. The nose radius is protected by a generous deposit of premium grade NASALLOY 8 hard facing alloy, which combats wear.

GB has introduced a new range of titanium sprocket nose carving bars to provide the fullest and most complete range for the carving industry.

GB's Titanium alloy steel carving bars are preferred by professional sculptors and are available in sprocket nose and hard nose in the following lengths 8", 10", 12", 14", 16" and 18".

Every year, chain saw sculpting becomes more and more prominent, and the sculpture more and more sophisticated and artistic. Today, chain saw sculptures are recognised as fine art, and the sculpting process is a popular form of entertainment. At shows and fairs around the world chain saw sculptors are busy plying their craft and selling their work for hundreds and sometimes thousands of dollars.

It's likely that most of your customers have been exposed and possibly intrigued by the art of chain saw sculpting. And, it's an art form that almost anyone can do with some level of success.

A good place to start is with a very fine textbook on this subject entitled "Chain Saw Carving--the Art and Craft" by noted, long-time U.S. sculptor, Hal MacIntosh. This 140- page manual covers the fundamentals of chain saw carving, including step-by-step instructions and detailed information about chain saws, carving accessories, and safety.

SPECIFICATIONS:

- Length:** 8" - 18"
- Groove:** .050"
- Pitch:** 3/8 LP", 1/4"
- Nose:** Nickel or Dime, Sprocket or Hard Tip.



To achieve ultra-precise wood shaping and sculpting, John Brady relies on GB Titanium Carving bars



TITANIUM CARVING

FEATURES - HARD NOSE

- One piece, solid, hi-tech titanium alloy steel body.
- Precision ground grooves; Uniform, induction-hardened rails.
- Laser cut for precision shape and fit up.
- NASALLOY 8 hard facing alloy extends well beyond nose radius.
- Grooves have rounded gullets for more strength.
- Slender body and extremely small nose radius.

BENEFITS - HARD NOSE

- Less friction in rails/ground radius strengthens rail base.
- Extremely easy maneuverability.
- Consistent groove width.
- Maximum chain and bar life.
- New hard facing alloy, NASALLOY 8, exceeds performance of other materials.
- Extremely tough and durable.
- Small nose radius allows for precise finish.

FEATURES - SPROCKET NOSE

- One piece, solid, hi-tech titanium alloy steel body.
- Precision ground grooves; Uniform, induction-harden rails.
- Laser cut for precision shape and fit up.
- Grooves have rounded gullets for more strength.
- Slender body and extremely small nose radius.
- Super tough, hi-tech alloy sprocket glides on precision swiss bearings.
- Easy replaceable sprocket nose.

BENEFITS - SPROCKET NOSE

- Less friction in rails/strengthen base of each rail.
- Extremely easy manoeuvrability.
- Consistent groove width.
- Maximum chain and bar life.
- Extremely tough and durable.
- Small nose radius allows for precise cut and finish.
- Fast chain speed.

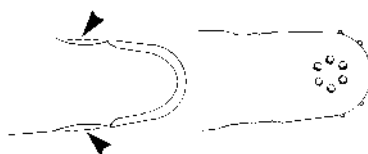
GB...using tomorrow's technology.



GUIDE BAR TROUBLESHOOTING

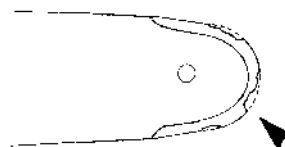
1.BAR CONDITION: Wearing behind the nose.

CAUSE: Loose chain.



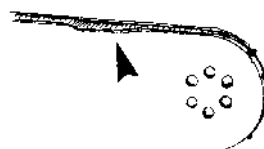
2.BAR CONDITION: Hard face weld break.

CAUSE: Pinching. Chain jumping rail.



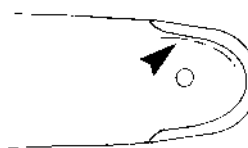
3.BAR CONDITION: Chipped rails.

CAUSE: Loose chain. Pinching.



4.BAR CONDITION: Spreading of nose.

CAUSE: Excessive side force. Throwing a chain.



5.BAR CONDITION: Worn rail

CAUSE: Poor lubrication. Dull chain.
Incorrectly sharpened chain or
abnormal use.



6.BAR CONDITION: Cracked rails

CAUSE: Pinching. Poor lubrication.



7.BAR CONDITION: Burning of nose

CAUSE: No lubrication. Nose pinched and friction
from sprocket or chain.



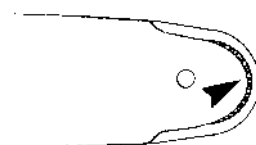
8.BAR CONDITION: Burning on rail

CAUSE: Rails pinched. No lubrication. Dull chain.



9.BAR CONDITION: Hard face wearing.

CAUSE: Excessive boring operation.
Tight chain tension. Poor lubrication.



GUIDE BAR MAINTENANCE

1. Clean oil holes and groove regularly.
2. Ensure chain is tensioned correctly.
3. Only use correctly sharpened chain.
4. Grease sprocket noses regularly
5. Square up bar rails often.
6. Replace sprocket nose before bar is totally damaged.



GB CHAIN SAW SPROCKETS -

Unequalled in performance

INNOVATION WITH NEW MATERIALS & NEW METHODS

GB chainsaw sprockets are superior unequalled. They are made to precise quality specifications and are available to fit every chainsaw. GB sprockets ensure transfer of power from the saw motor to the cutting chain. The positive drive action (which increases chain life) is achieved because every drive link mates with the face of each sprocket tooth.

GB machined sprockets are designed to get full power from motor to chain. Engineered for maximum chain flotation, GB sprockets reduce chain wear, last longer and give better performance.

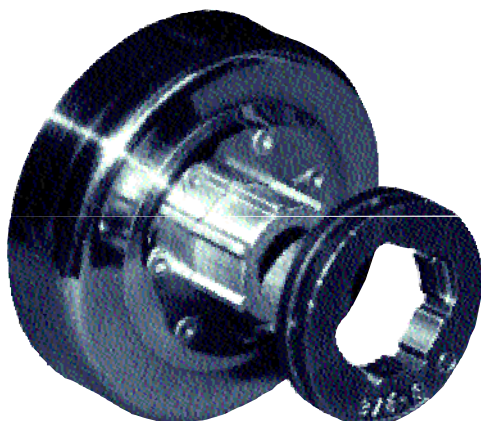
GB also has the most extensive range of sprockets across the world today. With competitors falling by the wayside, GB look at this as being a huge opportunity because of our superb quality and GB also guarantee the GB sprockets ensure a true performance with the best wear characteristics in the industry.

The spline hubs of our GB centre drive chainsaw sprockets are made from solid, hardened steel. Compare that to conventional spline hubs, which are formed from powder metal- a much weaker alternative. In addition, GB spline hubs are unequally double riveted to the sprocket drum, which is a much stronger connection than the copper brazing used by opposition sprockets.





CENTRE DRIVE SPROCKET (RIM-TYPE)



FEATURES:

- Exclusive joining system for drum and spline. First drum and spline combination made from 100% steel.
- Longer wearing spline.
- Double rivet connection.
- Precision spline and bore.
- Tighter tolerances.
- Investment-cast rim.
- Investment cast spline (only manufactured to do so), not powdered metal, (a weaker & cheaper alternative).
- Superior alloy steel.
- Wide and up-to-date range.
- Bearings and washers available.

BENEFITS:

- Extra strength.
- Extra life
- Better performance guaranteed.
- True alignment.
- Optimum wear life.
- Great service.
- Competitive pricing for an unbelievably good product.

GB...quality endorsed.



SPUR SPROCKET



FEATURES:

- Exclusive, three-way joining system, makes GB spur sprockets the strongest in the WORLD.
- Special carburised heat treatment hardens the spur and gives a longer life to the sprocket.
- Precision machined and engineered to exacting tolerances.
- Exact concentricity between spur and drum, delivers true performance.
- All sprockets are factory trimmed with precise finish and inspected.
- Wide and up-to-date range.
- Rust-proof coating.

BENEFITS:

- Stronger connection between drum and spur gives sprocket extra life.
- Extremely hard spur for longer, improved wear and tear.
- Better clutch grip and wear.
- Smoother cutting and better chain and bar wear.
- Perfect balance for peak performance

GB...real people for a real industry.

NOTES:





Innovators & Manufacturers of Precision Forestry Equipment

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