QUICK, FLEXIBLE AND COPLANAR

The unique Easy-clamping base serves as a quick clamping station for a variety of vices and extensions blocks.

Fixing, adjusting and removing to machine tables with t-slots is done in a few seconds by turning just a single screw.

MATCHING EASY-CLAMPING BASE

<table>
<thead>
<tr>
<th>BRILLANT</th>
<th>M</th>
<th>L</th>
<th>XL</th>
</tr>
</thead>
<tbody>
<tr>
<td>200</td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>220</td>
<td></td>
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<tr>
<td>230/250</td>
<td></td>
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<td></td>
</tr>
<tr>
<td>255/265</td>
<td></td>
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<tr>
<td>275</td>
<td></td>
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<td></td>
</tr>
<tr>
<td>285</td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>2000</td>
<td>*</td>
<td></td>
<td></td>
</tr>
</tbody>
</table>

* only conditionally recommended

MACHINE TABLE

All recent ATM machine tables are standardly equipped with t-slots. (retrofitting possible).

OPERATION

The flexible modular system of combining rotating and clamping with standard clamping elements saves from difficult and painstaking mounting of clamping tools into t-slots. Therefore the Easy-clamping system is a great benefit for your everyday work.
**EASY-CLAMPING BASE M**

Order No.: Z2236008
- for machine tables with T-slots
- incl. clamping key

WxHxD 15x80x200 mm

**DIRECT ADAPTATION**
- fast lock vice 50
- fast lock vice 60
- fast lock vice 80*
- clamping system X-Clamp 3858

*not suitable for Brilliant 220

**MATCHING MODULES**
- rotatable plate (base for headpieces and rotatable modules)
- head piece 1 (base for vacuum- and duo sample holder)
- head piece 2 (base for fast lock vice 50)
- head piece 3 (intermediate module for rotating plates)
- head piece 4 (base for fast lock vice 60)

**EASY-CLAMPING BASE L**

Order No.: Z2236011
- for machine tables with T-slots
- incl. clamping key

WxHxD 20x80x245 mm

**DIRECT ADAPTATION**
- fast lock vice 60
- fast lock vice 80
- adapter for universal vices:
  - V-block plate,
  - system height adapter,
  - guide bar with sliding carriage and V-groove block

**MATCHING MODULES**
- rotatable plate (base for headpieces and rotatable modules)
- head piece 1 (base for vacuum- and duo sample holder)
- head piece 2 (base for fast lock vice 50)
- head piece 3 (intermediate module for rotating plates)
- head piece 4 (base for fast lock vice 60)

**EASY-CLAMPING BASE XL**

Order No.: Z2236026
- for machine tables with T-slots
- incl. clamping key

WxHxD 20x100x400 mm

**DIRECT ADAPTATION**
- guide bar with sliding carriage 400 set
  (base for universal vice Mono 132 and chain clamping vice)
- universal power clamp 100/380

*only conditionally recommended*
Various Easy-clamping modules are a great benefit for your everyday work. The prooved fast lock vices combined with the Easy-clamping modules serve as a quick clamping station for a variety of vices and extensions blocks.

Changing of configured clamping vices with Easy-clamping bases is as fast than ever.

**SWIVELING, ROTATING, CLAMPING**

**ROTATABLE PLATE**
The rotatable plate is an intermediate module for angle adjustment with 15°-increments and a precision of 1/2°. The fitting head piece is easily to adapt to the clamping element by a quick holding fixture.

**CLAMPING MODULES XL**
Clamping of large components in large machines requires a very firm clamping tool. Therefore, the modules for the Easy-clamping system XL are a particularly strong. They can be built up only with power clamp 100/380 and the guide bar for universal vice Mono 132 and chain clamping vice.
**ROTATABLE PLATE**

Order No.: Z2236005

» quick holding fixture for quick and easy changing the head piece
» incl. clamping key

<table>
<thead>
<tr>
<th>Angle precision</th>
<th>1/2°</th>
</tr>
</thead>
<tbody>
<tr>
<td>Increments</td>
<td>15°</td>
</tr>
</tbody>
</table>

**MATCHING MODULES**

» Head piece 1 (base for vacuum- und Duo-sample holder)
» Head piece 2 (base for fast lock vice 50)
» Head piece 3 (intermediate module for rotatable plates)
» Head piece 4 (base for fast lock vice 60)
» Swiveling prism 60 and 100

---

**HEAD PIECE 1**

Order No.: Z2236006

» base for vacuum-/Duo-sample holder

---

**HEAD PIECE 2**

Order No.: Z2236007

» base for fast lock vice 50 and customized solutions

---

**HEAD PIECE 3**

Order No.: Z2236016

» intermediate module with angle 90° for adapting an additional rotatable plate
» with additional rotatable plate adaption for swiveling unit with fast lock vice 50 and 60
Cutting accessories

**HEAD PIECE 4**

Order No.: Z2236025

» base for fast lock vice 60 and customized solutions

---

**SWIVELING PRISM**

» for cylindrical samples Ø 4-20 mm
» swivel range adjustable 0-90°

Swiveling prism 60
Order No.: Z2236021

Swiveling prism 100
Order No.: Z2236023

---

**CLAMPING ELEMENT FOR HEADPIECE 1 | ROTATABLE PLATE**

**VACUUM SAMPLE HOLDER**

Order No.: Z2236002

» for thin section and unclampable samples

For microscope slide 28 x 48 mm

Vacuum pump
230 V/50 Hz (1Ph/N/PE)  
110 V/60 Hz (1Ph/N/PE)  
Order No.: Z1304600  
Order No.: Z1304634

---

**CLAMPING ELEMENT FOR HEADPIECE 1 | ROTATABLE PLATE**

**DUO SAMPLE HOLDER**

Order No.: Z2236003

» for thin section and target preparations
» clampable with quick holding fixture to parallel-grinding unit of Rubin 540
» 4 ball head screws

Max. sample size 30 x 55 mm

Cutting and grinding with just one mounting
Cutting accessories

**CLAMPING ELEMENT FOR HEADPIECE 3 | 2 ROTATABLE PLATES**

**SWIVEL UNIT VICE**

- **Base for fast lock vice 50**
  - Order No.: Z2236017

- **Base for fast lock vice 60**
  - Order No.: Z2236018

**MODULES FOR EASY-CLAMPING BASE L**

**SYSTEM-HEIGHT ADAPTER 50**

- Order No.: Z1304631
  - multiple mountable
  - base for fast lock vice 80
  - extension with V-block plate 40 for universal vices
  - incl. set of center bolts

  Construction height 50 mm

**V-BLOCK PLATE 40**

- Order No.: Z1304624
  - base for universal vices
  - for Easy-clamping base L (please order set of center bolts)
  - also usable without Easy-clamping base, incl. fasteners

  Construction height 40 mm
  T-slot 12 mm

**ACCESSORIES**

**SET OF CENTER BOLTS**

- Order No.: Z2236013
  - for mounting to Easy-clamping base or height-adapter
GUIDE BAR 400 SET
Order No.: Z1350024
» base for Universal vices Mono, Duo, chain clamping unit
» for clamping crankshafts, camshafts
» bar 400 mm, standard sliding carriage
» 1x V-groove block 120°
» 2x slanted resting blocks
» incl. fasteners for T-slot 12 mm

VERTICAL VICE
» for clamping of delicate, thin specimens
» integrated Easy-clamping base M or L
» incl. adjustable stop

VERTICAL VICE SINGLE
Order No.: Z2236009
» with Easy-clamping base M

Order No.: Z2236019
» with Easy-clamping base L

VERTICAL VICE DOUBLE
Order No.: Z2236010
» with Easy-clamping base M

Order No.: Z2236020
» with Easy-clamping base L

GUIDE BAR WITH SLIDING CARRIAGE AND V-GROOVE BLOCK
Order No.: Z1350001
» base for Universal vices Mono
» for clamping crankshafts, camshafts
» bar 280 mm, with sliding carriage, V-groove block
» incl. fasteners for T-slot 12 mm
**EASY-CLAMPING MODULES**

### UNIVERSAL-POWER CLAMPING SYSTEM 100/380

**Order N.: Z2234015**  
» integrated mechanical-hydraulic power  
» with standard clamping jaws plane/grooved, h 34 mm  
» incl. fasteners for T-slot nuts 12 mm and hand crank

<table>
<thead>
<tr>
<th>Specification</th>
<th>Value</th>
</tr>
</thead>
<tbody>
<tr>
<td>Clamping width</td>
<td>0 – 205 mm</td>
</tr>
<tr>
<td>Max. clamp force</td>
<td>25 kN</td>
</tr>
<tr>
<td>Weight</td>
<td>18.5 kg</td>
</tr>
<tr>
<td>WxHxD</td>
<td>100x104x466 mm</td>
</tr>
</tbody>
</table>

### UNIVERSAL-POWER CLAMPING SYSTEM 100/540

**Order N.: Z2234016**  
» integrated mechanical-hydraulic power  
» incl. fasteners for T-slot nuts 12 mm

<table>
<thead>
<tr>
<th>Specification</th>
<th>Value</th>
</tr>
</thead>
<tbody>
<tr>
<td>Clamping width</td>
<td>0 – 365 mm</td>
</tr>
<tr>
<td>Max. clamp force</td>
<td>25 kN</td>
</tr>
<tr>
<td>Weight</td>
<td>26.3 kg</td>
</tr>
<tr>
<td>WxHxD</td>
<td>100x104x625 mm</td>
</tr>
</tbody>
</table>

### V-Groove jaw

**Order N.: Z2234018**  
» horizontal V-groove  
» combinable with flat jaw h 80 mm  
» incl. fixing screws

<table>
<thead>
<tr>
<th>Dimension</th>
<th>Value</th>
</tr>
</thead>
<tbody>
<tr>
<td>WxH</td>
<td>100x80 mm</td>
</tr>
</tbody>
</table>

for clamping  
round material  
Ø 10 – 100 mm

### Flat jaw/h 80 mm

**Order N.: Z2234017**  
» grooved tightening surface  
» for clamping parallel specimens  
» combinable with V-groove jaw  
» incl. fixing screws

<table>
<thead>
<tr>
<th>Dimension</th>
<th>Value</th>
</tr>
</thead>
<tbody>
<tr>
<td>WxH</td>
<td>100x80 mm</td>
</tr>
</tbody>
</table>

### Angle drive

**Order N.: Z2234019**  
» crank with top operation
### Cutting accessories

#### FAST LOCK VICE 50

- **with manual force amplification**

| Jaws WxH  | 35x25 mm |
| Incl. accessories | Nutbreite 8 mm |

**Clamping range 50 mm**  
Order No.: Z2270002  
» lever left

Order No.: Z2270000  
» lever right

**Clamping range 100 mm**  
Order No.: Z2270003  
» lever left

Order No.: Z2270001  
» lever right

#### V-groove jaw

Order No.: 02270011

round materials  Ø 1-35 mm

---

#### FAST LOCK VICE 60

- **with force memory system**
- **horizontal fixation of round materials**

| Jaws WxH  | 60x32 mm |
| HxD      | 54x195 mm |

**Clamping range 120 mm**  
Order No.: Z2235002  
» lever left

Order No.: Z2235001  
» lever right

#### V-groove jaw

Order No.: 02235013

round materials  Ø 2-35 mm
FAST LOCK VICE 80

» with force memory system
» horizontal fixation of round materials

<table>
<thead>
<tr>
<th>Jaws W x H</th>
<th>80x35 mm</th>
</tr>
</thead>
<tbody>
<tr>
<td>H x D</td>
<td>71x203 mm</td>
</tr>
</tbody>
</table>

- **Clamping range 100 mm**
  - Order No.: Z2231001
  - » lever left

- **Clamping range 150 mm**
  - Order No.: Z2231002
  - » lever left

- **Order No.: Z2231003**
  - » lever right

- **Order No.: Z2231004**
  - » lever right

V-groove jaw

Order No.: 02231016

- Round materials Ø 2-40 mm

Rotating plate 2x 60°

Order No.: Z1304560

» manual rotation of clamping tool
» manual horizontal move on machine table

- Clamping range 100 mm
- Swivel range +/- 60°
CROSS VICE
» especially suitable for samples which contract during cutting process by material tension: the samples are pulled apart by the transversely exciting jaws
» for parallel clamping of round and rectangular samples, particular for longitudinal cutting through hardened materials
» excentric clamping arrangement allows rapid changing of samples

BRILLANT 200 230 250 255 265

BRILLANT 255* 265 275 285 2000
* auf Anfrage

BRILLANT 275 285 2000

CROSS VICE 50/100
Order No.: Z1340010
» counter holder adjustable

<p>| | |</p>
<table>
<thead>
<tr>
<th></th>
<th></th>
</tr>
</thead>
<tbody>
<tr>
<td>WxH</td>
<td>50 x 50 mm</td>
</tr>
<tr>
<td>Round materials</td>
<td>Ø max. 60 mm</td>
</tr>
<tr>
<td>Clamping range</td>
<td>max. 100 mm</td>
</tr>
<tr>
<td>Incl. accessories</td>
<td>T-slot 12 mm</td>
</tr>
</tbody>
</table>

CROSS VICE 80/100
Order No.: Z1340000
» counter holder adjustable

<p>| | |</p>
<table>
<thead>
<tr>
<th></th>
<th></th>
</tr>
</thead>
<tbody>
<tr>
<td>WxH</td>
<td>80 x 50 mm</td>
</tr>
<tr>
<td>Round materials</td>
<td>Ø max. 90 mm</td>
</tr>
<tr>
<td>Clamping range</td>
<td>max. 100 mm</td>
</tr>
<tr>
<td>Incl. accessories</td>
<td>T-slot 12 mm</td>
</tr>
</tbody>
</table>

CROSS VICE 80/150
Order No.: Z1340001
» counter holder adjustable

<p>| | |</p>
<table>
<thead>
<tr>
<th></th>
<th></th>
</tr>
</thead>
<tbody>
<tr>
<td>WxH</td>
<td>80 x 50 mm</td>
</tr>
<tr>
<td>Round materials</td>
<td>Ø max. 90 mm</td>
</tr>
<tr>
<td>Clamping range</td>
<td>max. 150 mm</td>
</tr>
<tr>
<td>Incl. accessories</td>
<td>Nutbreite 12 mm</td>
</tr>
</tbody>
</table>

EXPANSION CLAMPING DEVICE
Order No.: Z1304636
» to release material tension of cylindrical, hollow workpieces

<p>| | |</p>
<table>
<thead>
<tr>
<th></th>
<th></th>
</tr>
</thead>
<tbody>
<tr>
<td>Inner sample Ø</td>
<td>55 – 120 mm</td>
</tr>
<tr>
<td>Adjustment*</td>
<td>ca. 10 mm</td>
</tr>
</tbody>
</table>
* extendable by exchange of cylindrical pins
### ANGLE VICE 60

**Order No.: Z1304001**
- Vertically centered, stainless
- 2x plain jaws

<table>
<thead>
<tr>
<th>Sample-Ø</th>
<th>max. 60 mm</th>
</tr>
</thead>
<tbody>
<tr>
<td>V-groove jaw</td>
<td></td>
</tr>
<tr>
<td>Clamping range</td>
<td>55 mm</td>
</tr>
<tr>
<td>Rotatable</td>
<td>270°</td>
</tr>
<tr>
<td>Incl. accessories</td>
<td>T-slot 12 mm</td>
</tr>
</tbody>
</table>

**V-groove jaw**
**Order No.: 01304008**

Round materials Ø 10-60 mm

### ANGLE VICE 80

**Order No.: Z1302000**
- Vertically centered, stainless
- 2x plain jaws

<table>
<thead>
<tr>
<th>Sample-Ø</th>
<th>max. 60 mm</th>
</tr>
</thead>
<tbody>
<tr>
<td>V-groove jaw</td>
<td></td>
</tr>
<tr>
<td>Clamping range</td>
<td>70 mm</td>
</tr>
<tr>
<td>Rotatable</td>
<td>270°</td>
</tr>
<tr>
<td>Incl. accessories</td>
<td>T-slot 12 mm</td>
</tr>
</tbody>
</table>

**V-groove jaw**
**Order No.: 01302016**

Round materials Ø 10-60 mm

### ROTATING VICE 60

**Order No.: Z1304002**
- Vertically centered, stainless
- 2x plain jaws

<table>
<thead>
<tr>
<th>Sample-Ø</th>
<th>max. 60 mm</th>
</tr>
</thead>
<tbody>
<tr>
<td>V-groove jaw</td>
<td></td>
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<tr>
<td>Clamping range</td>
<td>max. 55 mm</td>
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<tr>
<td>Sample-Ø</td>
<td>Ø 60 mm</td>
</tr>
<tr>
<td>Swivel range</td>
<td>90°</td>
</tr>
<tr>
<td>Incl. accessories</td>
<td>T-slot 12 mm</td>
</tr>
</tbody>
</table>

**V-groove jaw**
**Order No.: 01304008**

Round materials Ø 10-60 mm
**CLAMPING SYSTEMS**

**UNIVERSAL POWER CLAMPING SYSTEM LC 90**

Order No.: Z2234001
- easy and safe clamping of various workpieces
- various clamping jaws available
- up to 28 kN tension with modest effort through mechanical power transmission
- adjustable clamping force (11 settings)
- incl. fasteners for t-slot nuts 12 mm and hand crank

**ACCESSORIES**

**CLAMPING JAWS**

**Carrier jaws LC 90**
Order No.: Z2234003
- 1 pair, base for V-groove jaw and flat jaw 100
- easy fastening with just one screw
- made of high-strength aluminium with ceramic coating

**V-groove jaw 100**
Order No.: Z2234004
- 1 piece, combinable with flat jaw 100
- rotatable jaw (case-hardened steel)
- jaw size (WxH) 100 x 70 mm
- two horizontal V-grooves
- for clamping round material between Ø 10 and 100 mm
- incl. fixing screw

**Flat jaw 100**
Order No.: Z2234005
- 1 piece, combinable with flat jaw 100
- rotatable jaw (case-hardened steel)
- jaw size (WxH) 100 x 70 mm
- flat tightening surface
- for clamping parallel specimens
- incl. fixing screw

**QUICK-CHANGING DEVICE**

Order No.: Z2234009
- 1 pair
- quick and easy connection of modules by using pull-down-studs
- for fixation of step jaw 100
- clamping system X-Clamp 100
- customized clamping solutions

**STEP JAW 100**

Order No.: Z2234008
- 1 pair
- clamping of parallel workpieces
- application of clamping force via basic module LC 90
- 180° rotatable
- use only with quick changing device

**CLAMPING SYSTEM X-CLAMP 100**

Order No.: Z2234002
- 1 pair
- individual and safe clamping of various specimen shapes and sizes with spring suspended stainless steel plungers
- perfect form fit with minimal effort
- time-saving
- use only with quick-changing device
- incl. torque wrench and fixing screws
**BASE 90°**

Order No.: Z2234006

» for installing the basic module LC 90 in side position 90°

» incl. fixing material for T-slot nut DIN 650 12 mm

---

**SUPPORT MODULE**

Order No.: Z1350023

» 1 piece

» for supporting long workpieces

» reducing of vibrations

» spring suspended plungers fit tightly to the specimen

» fixation of plungers

» supplementary fixation of workpiece from above possible with universal vice

» quick and easy connection of modules by using pull-down studs

---

**CUSTOMIZED CLAMPING JAWS**

» ATM-service: send us your drawing (DXF or DWG-file) or fotos of your workpiece.

We will design your individually optimized clamping vice.
CLAMPING SYSTEM X-CLAMP 3858

Order No.: Z2234010
- individual and safe clamping of various smaller specimen shapes and sizes with spring suspended stainless steel plungers
- perfect form fit with minimal effort
- time-saving
- incl. torque wrench

Plunger area WxH 23x20 mm
Plunger stroke 12 mm
Max. clamping width 118 mm

BASE FOR CLAMPING SYSTEM X-CLAMP 3858

Order No.: Z2234012
- for fixation with T-slot nut 8 mm

Order No.: Z2234011
- for fixation with T-slot nut 12 mm

BRILLANT 200 220 230 250
Cutting accessories

**UNIVERSAL VICE PICCOLO 54**

Order No.: Z1350008
» incl. handle

- Working radius: 54 mm
- Clamping height: 15 - 58 mm
- Clamping force: 6.5 kN
- Fixing screws: M 8 x 25
- T-slot nut stainless: M 8 x 12

**UNIVERSAL VICE PICCOLO 100**

Order No.: Z1350012
» incl. handle

- Working radius: 100 mm
- Clamping height: 40 - 90 mm
- Clamping force: 4.2 kN
- Fixing screw: M 8 x 25
- T-slot nut stainless: M 8 x 12

**UNIVERSAL VICE MONO 61**

Order No.: Z1350002
» incl. handle

- Working radius: 61 mm
- Clamping height: 8 - 102 mm
- Clamping force: 12 kN
- Fixing screw: M 10 x 32
- T-slot nut stainless: M 10 x 12

**UNIVERSAL VICE MONO 132**

Order No.: Z1350011
» incl. handle

- Working radius: 132 mm
- Clamping height: 43 - 155 mm
- Clamping force: 8 kN
- Fixing screw: M 10 x 32
- T-slot nut stainless: M 10 x 12

**UNIVERSAL VICE MONO 132**
**UNIVERSAL VICES**

**UNIVERSAL VICE DUO**

Order No.: Z1350005

- for clamping and lifting
- with 2 changeable clamping arms
- incl. handle

- Working radius: 46 - 91 mm
- Clamping height: 0 - 129 mm
- Lifting height: 4 - 142 mm
- Clamping force: 11 kN
- Fixing screw M 10 x 32
- T-slot nut stainless M 10 x 12

**CHAIN CLAMPING VICE**

Order No.: Z1350006

- for clamping of big parts
- 1x universal vice Mono
- 1x chain (length 1 m)
- 1x hooking block for chain
- incl. handle

- Clamping force: 16 kN
- Fixing screw M 10 x 32
- Fixing screw M 10 x 25
- DIN 912
- 2x T-slot nut stainless M 10 x 12

**ACCESSORIES**

**CLAMPING SHOES**

- for all universal vices

**Longitudinal V-shoe**

Order No.: 92005796

**Traverse V-shoe**

Order No.: 92005797

**Longitudinal bridge**

Order No.: 92005799

**Traverse bridge**

Order No.: 92005800

**Standard clamping shoe**

Order No.: 92005798

**FIXATION**

**Fixing screw**

- for universal vice Piccolo
  - M 6 x 25 Order No.: Z1304591
  - M 8 x 25 Order No.: 95003169
  - M 10 x 25 Order No.: 95003170

- for universal vice Mono, Duo, chain clamping system
  - M 10 x 32 Order No.: 95003168

**T-slot nut stainless**

- M 6 x 8 Order No.: 91001157
- M 8 x 10 Order No.: 91001161
- M 8 x 12 Order No.: 91001159
- M 10 x 12 Order No.: 91001158

*other sizes on request
Different types of tasks and conditions constitute diverse demands on clamping tools and cutting equipment. The construction of our machines gives us the opportunity to design and manufacture custom-made solutions for special dimensions. ATM has already successfully developed special clamping tools for complicated cutting movements or geometries.

**ACCESSORIES**

**HEIGHT ADAPTER PICCOLO**

Order No.: Z1350007

- Construction height: 60 mm
- Fixing screw: M 8 x 25
- T-slot nut, stainless: M 8 x 12

**HEIGHT ADAPTER MONO**

Order No.: Z1350003

- Construction height: 74 mm
- Fixing screw: M 10 x 32
- T-slot nut, stainless: M 10 x 12

**CLAMPING ARM EXTENSION**

Order No.: 95003172

- for Piccolo 54 and Mono 61

- Extension: 90 mm
- Clamping shoe: Standard

**PAIR OF V-BLOCKS**

Order No.: 92005805

- Angle: 90°
- for samples: Ø 5 - 50 mm
- D x W: 50 x 150 mm

**CUSTOMIZED CLAMPING TOOLS**

ADAPTABLE TO UNIVERAL VICE MONO:

- see at Easy-clamping modules for Easy-clamping base L
- see at Easy-clamping modules for Easy-clamping base XL
- direct adaption: Brilliant 275, 285 and 2000

**UNIVERSAL VIces**

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