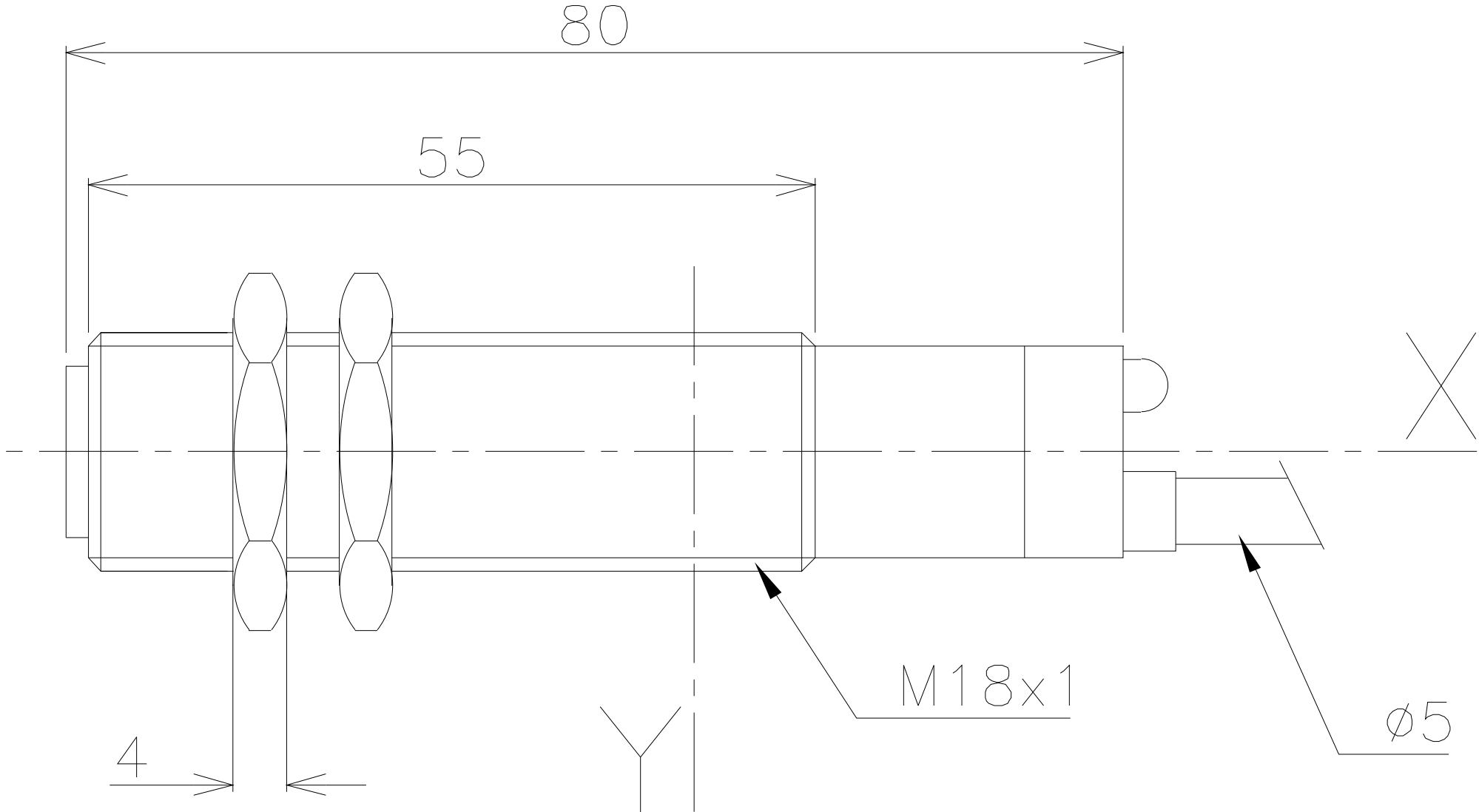
80
55
X
Y
M18x1
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4