

# TMO - 01

U. S. MIL-GRADE MANUFACTURING TECHNICAL MANUAL  
AND OPERATION

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MG-15 ENHANCED WITH  
SYMMETRICAL, AMBIDEXTROUS,  
ERGONOMIC BOLT CATCH, RELEASE  
(SAEBR) SYSTEM



See Back Cover for Distribution Statement and Destruction Notice

U. S. MIL-GRADE MANUFACTURING, USA 2025

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# 1. SAFETY

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## 1.1 PRECAUTIONS

 **WARNING:** THIS MANUAL COVERS THE MG-15E LOWER RECEIVER AND ITS INTEGRATED SAEBR SYSTEM. THE MG-15E IS A SERIALIZED FIREARM COMPONENT AND MUST BE HANDLED WITH THE SAME CARE AS A COMPLETE FIREARM. WHEN ASSEMBLED, THIS U. S. MIL-GRADE MANUFACTURING (USMGM) PRODUCT IS POTENTIALLY LETHAL. IT IS CLASSIFIED AS A FIREARM OR DANGEROUS WEAPON BY THE BUREAU OF ALCOHOL, TOBACCO, FIREARMS AND EXPLOSIVES (ATF).

 **WARNING:** READ AND FULLY UNDERSTAND THIS ENTIRE USER MANUAL BEFORE REMOVING THE PRODUCT FROM ITS PACKAGING. YOUR SAFETY, AND THE SAFETY OF OTHERS, DEPENDS UPON YOUR STRICT ADHERENCE TO THE BASIC INSTRUCTIONS REGARDING THE SAFE HANDLING, OPERATION, AND FUNCTION OF THIS U. S. MIL-GRADE MANUFACTURING PRODUCT.

 **WARNING:** WHEN THIS LOWER RECEIVER IS ASSEMBLED INTO A FIREARM, CARELESS, NEGLIGENT, OR IMPROPER HANDLING MAY RESULT IN AN UNINTENTIONAL DISCHARGE, WHICH COULD CAUSE SERIOUS INJURY, DEATH, OR DAMAGE TO PROPERTY.

**NOTICE:** U. S. MIL-GRADE MANUFACTURING shall not be liable for any injury, loss of life, or property damage resulting from intentional, unintentional, or accidental discharge of the firearm assembled from this product, or from any firearm function arising from use for a purpose for which it was not designed. U. S. MIL-GRADE MANUFACTURING will not honor claims arising from careless or improper handling, unauthorized use, unauthorized adjustment, or the installation of unauthorized parts. U. S. MIL-GRADE MANUFACTURING will not honor claims resulting from corrosion, neglect, misuse, the use of incorrect or improper-caliber ammunition, or the use of ammunition other than new, high-quality, commercially manufactured ammunition in good condition. Any such claims, regardless of cause or circumstance, will also not be honored by U. S. MIL-GRADE MANUFACTURING when made by a second or subsequent owner of the firearm.

 **CAUTION:** BEFORE LEAVING THE U. S. MIL-GRADE MANUFACTURING FACILITY, THIS PRODUCT WAS INSPECTED THROUGHOUT THE MANUFACTURING PROCESS, ASSEMBLED BY A TRAINED U. S. MIL-GRADE MANUFACTURING PROFESSIONAL, TESTED BY QUALITY ASSURANCE PERSONNEL, AND PROPERLY PACKAGED. ONCE THE PRODUCT HAS LEFT THE U. S. MIL-GRADE MANUFACTURING FACILITY, THE COMPANY HAS NO CONTROL OVER ITS HANDLING OR STORAGE. THEREFORE, AT THE TIME OF PURCHASE, CAREFULLY

EXAMINE THE PRODUCT TO CONFIRM THAT IT IS UNLOADED (IF APPLICABLE) AND FREE FROM DAMAGE. IF PURCHASING FROM AN AUTHORIZED DEALER AND/OR DISTRIBUTOR, THEY WILL ASSIST WITH THIS EXAMINATION AND ADDRESS ANY QUESTIONS YOU MAY HAVE.

The FIELD version of this instruction manual must always accompany the firearm. If you loan, transfer, or sell the firearm, ensure that the FIELD manual is included. Always comply with all applicable federal, state, and local laws and regulations governing lawful possession, transfer, storage, and use of this firearm.

If you are unfamiliar with firearms or their safe operation, seek professional instruction through reputable firearms safety courses offered by qualified instructors, recognized training organizations, or local shooting clubs.

## 1.2 WARNINGS AND CAUTIONS

Throughout this manual, **WARNINGS** and **CAUTIONS** are preceded by the following symbol . All **WARNINGS** and **CAUTIONS** must be read carefully and followed exactly as written.

Read and understand every **WARNING** and **CAUTION** before removing the product from its packaging or attempting to operate it.

**NOTE:** Although this manual is specific to the MG-15E lower receiver, it is a serialized firearm component intended to be incorporated into a complete firearm. Accordingly, many of the warnings and cautions contained herein apply to situations in which the MG-15E is fully or partially assembled into an operational firearm.

**⚠ WARNING:** When you place your finger on the trigger, you must expect the firearm to discharge. You accept full responsibility for every round fired. Careful adherence to safety rules prevents unintentional discharge and avoids injury, death, or property damage.

**⚠ WARNING:** Careless, negligent, or improper handling can result in an unintended discharge that may cause serious injury, death, or property damage.

**⚠ WARNING:** This firearm may discharge when a round is chambered, if it is dropped, jarred, struck, or receives impact to the muzzle or front of the firearm. This can occur regardless of the position of the safety selector, hammer, or other mechanical safeties, and without the trigger being pulled. Strict adherence to safety procedures is mandatory to minimize risk.

**⚠ WARNING:** Always handle your firearm as though it is loaded.

**⚠ WARNING:** Never point your firearm at anything you do not intend to destroy.

**⚠ WARNING:** Never rely on anyone else's statement that a firearm is unloaded. Verify personally with the firearm pointed in a safe direction and your finger off the trigger.

**⚠ WARNING:** Never leave a loaded firearm unattended. Unauthorized access, especially by a child, can result in injury, death, or property damage.

**⚠ WARNING:** Never leave a firearm cocked and ready to fire. This condition is extremely dangerous and increases the risk of accidental discharge.

## **DROP, IMPACT, AND MECHANICAL DAMAGE WARNINGS**

**⚠ WARNING:** Dropping or striking the firearm may cause internal damage that is not visible externally. A damaged firearm may discharge unexpectedly and cause injury, death, or property damage. If the firearm has been dropped or

subjected to impact, have it inspected by a qualified gunsmith before further use.

**⚠ WARNING:** Do not alter or modify any part of the firearm. Alterations may reduce safety margins, cause premature wear, or lead to malfunction. A malfunction can result in accidental discharge and serious injury or death. If any component does not function correctly, have the firearm inspected by a qualified gunsmith.

### **COOK-OFF AND HEAT WARNINGS**

**⚠ WARNING:** If the barrel becomes extremely hot from repeated firing, a cartridge left in the chamber may discharge due to heat transfer ( “cook-off” ). This can occur at any time when the chamber is hot. If conditions for a potential cook-off are suspected, immediately clear the chamber after firing.

### **EJECTION PORT AND BOLT WARNINGS**

**⚠ WARNING:** Keep yourself and others clear of the ejection port during firing.

Spent casings are expelled with significant force and may cause injury.

Obstructing the ejection port can cause malfunction.

Never place fingers inside the ejection port. Hot metal or forward movement of the bolt can cause burns or injury.

## AMMUNITION AND EQUIPMENT CAUTIONS AND WARNINGS

 **CAUTION:** Always ensure the chamber, bore, gas system, suppressor (if equipped), and action are clean and free of obstructions before firing. Keep the firearm clean and properly lubricated for safe and reliable operation.

 **WARNING:** Use only high-quality, factory-manufactured ammunition that is clean, dry, in good condition, and of the correct caliber. Hand-loaded, reloaded, or remanufactured ammunition may fall outside established engineering safety standards and may cause malfunction, firearm damage, injury, or death.

 **WARNING:** Inspect ammunition before using the forward assist. Forcing damaged or defective ammunition into the chamber may damage the firearm and lead to injury or property damage.

## SHOOTING SAFETY WARNINGS

 **WARNING:** Never consume alcohol or use drugs before or while handling or shooting firearms. Alcohol, drugs, or certain medications impair judgment, coordination, and

reaction time. Consult a qualified physician if taking medication to ensure you can safely handle firearms.

 **WARNING:** Always wear appropriate personal protective equipment, including eye and hearing protection, when shooting or when near others who are shooting.

Failure to use proper hearing protection may cause permanent hearing loss.

Failure to wear eye protection may result in blindness or injury from flying debris, gas, or ricochet fragments.

Encourage spectators and bystanders to wear protective equipment.

 **WARNING:** Always keep the safety selector in the “SAFE” position until your sights are on target and you are ready to fire.

Never rely solely on any mechanical safety device. Mechanical safeties can fail and do not replace safe handling.

Always verify the firearm's condition by removing the magazine, locking the bolt to the rear (if applicable), and visually and physically inspecting the chamber.

**⚠ WARNING:** Always be certain of your target and what lies beyond it.

Bullets can travel great distances and remain lethal.

Ensure your backstop is adequate to stop and contain projectiles.

If you have any doubt about your target, surroundings, or backstop—do not fire.

**⚠ WARNING:** Never shoot at hard surfaces such as rock, or at liquid surfaces such as water. Ricochets may occur and projectiles may travel unpredictably, causing injury, death, or property damage.

**⚠ WARNING:** Never discharge a firearm near flammable or explosive materials. Flames, sparks, and hot gases may ignite combustible substances.

**⚠ WARNING:** Never follow another person while your firearm is loaded and ready to fire. Maintain the safety selector on SAFE and control muzzle direction at all times.

## **WATER AND OBSTRUCTION WARNINGS**

**⚠ WARNING:** Never fire the firearm if water is present in the barrel or gas system.

If exposed to heavy rain, fog, or moisture, open the action and allow water to drain before firing.

Clean and lubricate the firearm promptly after exposure to moisture.

## **MALFUNCTION WARNINGS**

 **WARNING:** If the firearm fails to fire:

- 1) Keep the firearm pointed in a safe direction.
- 2) Wait at least 30 seconds in case of a hang fire (delayed ignition).
- 3) If the round does not fire:
  - a. Cycle the bolt to eject the cartridge.
  - b. Inspect the primer.
  - c. If the firing pin mark is light, off-center, or absent, discontinue firing and have the firearm examined by a qualified gunsmith.
  - d. If the firing pin indentation appears normal, assume defective ammunition. Segregate the round from live ammunition and dispose of it according to manufacturer guidelines.

**NOTE:** A light firing pin mark may appear on unfired cartridges that were chambered and extracted. Dispose of misfired cartridges according to the ammunition manufacturer's instructions.

## **CLEANING AND STORAGE WARNINGS**

 **WARNING:** Always verify the firearm is completely unloaded before cleaning or storage.

 **WARNING:** Store firearms and ammunition separately, locked, and out of reach of unauthorized persons.

Keep firearms secured from children and untrained individuals.

Secure firearms and ammunition to prevent unauthorized access.

## **FIREARM ABUSE WARNINGS**

 **WARNING:** Never mistreat, abuse, or mishandle your firearm.

Carry and use it with care.

Use it only for its intended purpose.

Never dry fire the firearm when the upper and lower receivers are separated, as this may damage components.

Never modify internal parts.

### **SUPPRESSOR HANDLING WARNINGS (IF EQUIPPED)**

 **WARNING:** Ensure suppressor components, including any baffles, are securely installed before firing.

Improper installation may result in serious injury.

Never fire the firearm if liquid (oil, solvent, or other fluid) is present inside the suppressor, unless it is a liquid and quantity that is explicitly called for by the suppressor manufacturer for enhanced sound suppression.

In suppressors not designed for use with liquids, liquid in the suppressor may create dangerous pressure spikes.

 **WARNING:** Suppressors become extremely hot during firing and retain heat for extended periods.

Avoid contact with skin or flammable materials.

Do not rest a hot suppressor against surfaces that may melt or ignite.

 **WARNING:** Unauthorized modification of suppressor components may violate applicable laws.

Contact the manufacturer for assistance with suppressor repairs or troubleshooting.

## **LEAD & CHEMICAL EXPOSURE**

 **WARNING:** Firing firearms and handling firearms/ammunition can expose you to lead and other combustion byproducts. Avoid eating, drinking, or smoking while handling firearms or ammunition.

Wash hands thoroughly after handling firearms, ammunition, spent casings, or cleaning patches.

If you are a resident of California, Proposition 65 warnings may apply: [www.P65Warnings.ca.gov](http://www.P65Warnings.ca.gov).

## **1.3 BASIC FIREARM HANDLING**

Regardless of your level of familiarity with firearms, we strongly encourage you to read this entire instruction manual from beginning to end.

1) ALWAYS handle every firearm as though it is loaded.

- a. Never rely solely on another person's statement that a firearm is unloaded.
  - b. Personally conduct a visual inspection of the chamber (and the magazine, if applicable) to confirm the firearm is completely unloaded—even if you just observed someone else perform the inspection.
  - c. Before placing a firearm down or handing it to another individual, always remove the magazine and lock the bolt to the rear.
  - d. Do not load the firearm until you are prepared and ready to shoot.
- 2) NEVER allow the muzzle to point at anything you do not intend to destroy.
- a. Be constantly aware of where the muzzle is directed whenever you are carrying or handling the firearm.
  - b. Always unload the firearm before traversing challenging terrain such as fences, steep inclines, rocky or unstable ground, elevated platforms, tree stands, or similar obstacles.

3) ALWAYS keep your finger away from the trigger until your sights are aligned with the target.

a. Keep your finger indexed along the receiver or resting on the trigger guard until you are fully prepared to fire.

4) ALWAYS confirm your target and what lies beyond it before firing.

a. Know what is positioned behind your intended target in the event the projectile passes through it.

b. Be aware of where the projectile may travel if you miss your intended target.

c. Ensure that your backstop is sufficient in both strength and size to safely stop the projectile and account for any errant shots.

d. Do not fire at or near rocks, hard surfaces, water, or any surface that may cause a ricochet or redirect the projectile in an unpredictable manner that could result in injury, death, or property damage.

5) NEVER leave a firearm unattended or unsecured.

- a. An unattended firearm may be accessed by another person, including a child, which could lead to property damage, serious injury, or death.
- b. Educate children and all household members about firearm safety and ensure they understand the importance of respecting firearms and muzzle discipline at all times, regardless of whether the firearm is loaded or unloaded.
- c. Seek instruction from a qualified firearms instructor for proper training and closely supervise all firearm-related activities.
- d. YOU ARE ACCOUNTABLE FOR YOUR FIREARM!

#### 1.4 LEGAL COMPLIANCE

 **CAUTION:** This product is subject to federal, state, and local laws. It is the purchaser's responsibility to ensure lawful possession, transfer, transport, and use.

The MG-15E must be shipped and received in accordance with applicable law (e. g., via an FFL).

## 2. RECEIVER OVERVIEW

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US Patent Pending

The SAEBR System typically requires a simple break-in procedure when new from the factory. Refer to section 2.2 for instructions.

### 2.1 OPERATION OF SAEBR SYSTEM

 **WARNING:** The SAEBR System is intended to be used with the firing hand of the operator while holding the pistol grip. The trigger finger shall remain clear of the trigger and extend fully forward to contact the Finger Pad (refer to section 3.1 for component identification).

Keep your finger outside the trigger guard until you intend to fire. Ensure you can operate controls without contacting the trigger.

 **WARNING:** Always keep the muzzle pointed in a safe direction during any manipulation of controls.

**⚠ WARNING:** If you touch the trigger, you must expect the firearm to discharge. Maintain strict trigger discipline at all times.

**⚠ WARNING:** Before live fire, and especially after assembly, or any maintenance, perform a safe functions check (with the firearm unloaded).

**⚠ CAUTION:** Do not use the firearm if controls feel damaged, loose, or do not operate smoothly. Discontinue use and contact a qualified gunsmith or U.S. MIL-GRADE MANUFACTURING.

**Engaging the bolt catch:** With the tip of the trigger finger on the underside of the Finger Pad, lift upwards to engage the bolt catch mechanism. Simultaneously charge the bolt fully to the rear with the charging handle, then release and stow the charging handle back into position. The bolt carrier is now locked.

**Releasing the bolt catch:** With the tip of the trigger finger on the top side of the Finger Pad, slide, or push downwards (not inwards) until the bolt carrier group is released and sent into battery.

## 2.2 BREAK-IN PROCEDURE FOR SAEBR SYSTEM

 **WARNING:** Perform all break-in cycling with the firearm UNLOADED and pointed in a safe direction.

 **CAUTION:** Remove all ammunition from the work area during break-in and function checks.

 **CAUTION:** Avoid using incomplete firearms during the break-in procedure to prevent internal component damage.

Fully assemble the MG-15E lower receiver and attach to a completed upper receiver to allow cycling of the bolt carrier group. Ensure the firearm is unloaded and do not insert a magazine. Charge the weapon with the weapon's charging handle and use the SAEBR System Finger Pad to catch and subsequently release the bolt carrier group. Perform this catch and release of the bolt carrier group 20 times until the SAEBR System slides smoothly up and down.

If actuation of the Finger Pad does not feel smooth, perform another 20 cycles, then disassemble the SAEBR components and wipe all surfaces on the Vertical Link and along the channel in the receiver clean. Apply a very light  
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coat of CLP or comparable gun oil to the sliding surfaces and reassemble. If roughness persists, contact U.S. MIL-GRADE MANUFACTURING customer support for help.

## 2.3 CARE AND MAINTENANCE INTERVALS

 **WARNING:** ALWAYS ensure the firearm is unloaded before cleaning, lubricating, adjusting, or performing maintenance. Remove the magazine, lock the bolt to the rear, and visually/physically inspect the chamber.

 **WARNING:** Allow the firearm and all components to cool to room temperature before maintenance. Hot surfaces can cause burns.

 **WARNING:** Wear eye protection. Solvents, oils, and parts under spring tension can eject or splash with enough force to cause severe injury.

 **CAUTION:** Use only firearm-appropriate solvents and lubricants in a well-ventilated area. Keep chemicals away from open flame and follow manufacturer safety instructions.

**⚠ CAUTION:** Keep small components organized during maintenance. Loss or incorrect installation of small parts can cause unsafe operation.

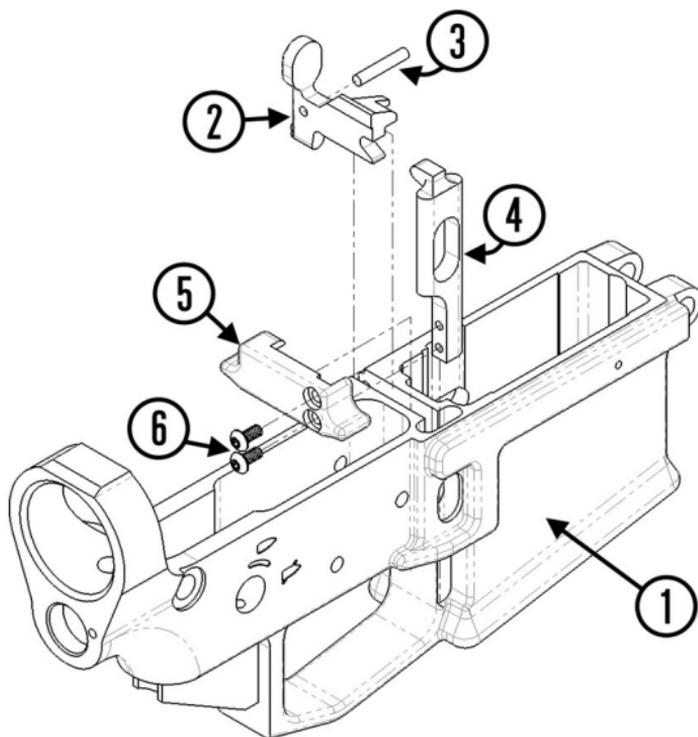
**⚠ CAUTION:** Do not over-tighten fasteners. Use the correct tools (T8 Torx and 1/32 Allen as specified) and apply appropriate torque. Stripped fasteners or damaged threads can compromise safety and reliability.

The SAEBR System does not require regular maintenance, however, experiences may vary depending on the type of ammunition used and environmental exposure. Inspect for debris buildup around the top of the Vertical Link and channel, as well as the mating surfaces of the Vertical Link and Enhanced Bolt Catch.

### 3. SAEBR SYSTEM COMPONENTS

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#### 3.1 COMPONENT EXPLODED VIEW



1. MG-15E LOWER RECEIVER
2. ENHANCED BOLT CATCH
3. THREADED BOLT CATCH RETAINING PIN
4. VERTICAL LINK
5. FINGER PAD
6. 4-40 T8 TORX SCREWS

## 4. DISASSEMBLY AND REASSEMBLY OF SAEBR SYSTEM

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**⚠ CAUTION:** Many AR-pattern components are spring-loaded and may eject suddenly during assembly or disassembly. Examples include, but are not limited to: SAEBR System catch spring, detent pins and detent springs (selector, takedown, pivot), magazine catch spring, buffer retainer and spring, trigger/hammer springs, and related pins.

**⚠ CAUTION:** Wear eye protection during all disassembly/assembly steps.

**⚠ CAUTION:** Control parts during removal; cover detents/springs with a hand or shop towel to prevent loss.

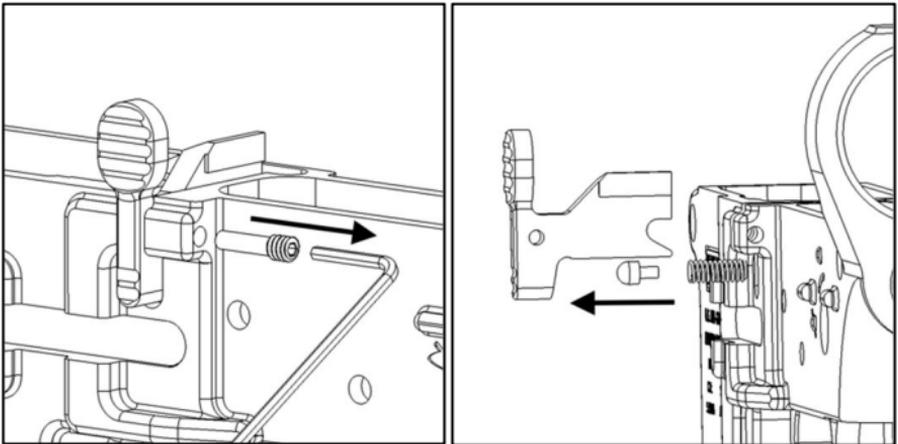
**⚠ CAUTION:** Work in a clean, well-lit area. Losing detents/springs can render the firearm unsafe or inoperable.

**⚠ CAUTION:** Do not substitute springs/detents with non-spec parts. If a component is lost or damaged, replace with correct-spec parts before use.

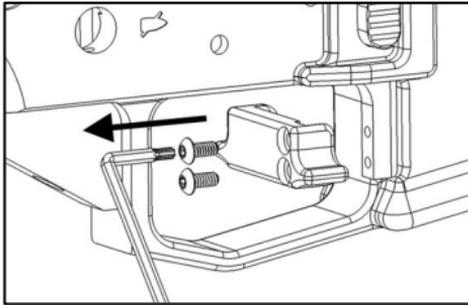
Maintenance does not require complete disassembly of the SAEBR system. Only perform full disassembly to replace damaged parts or when excessive buildup causes malfunctioning.

Tools required: T8 Torx wrench, 1/32 Allen wrench, stick or something.

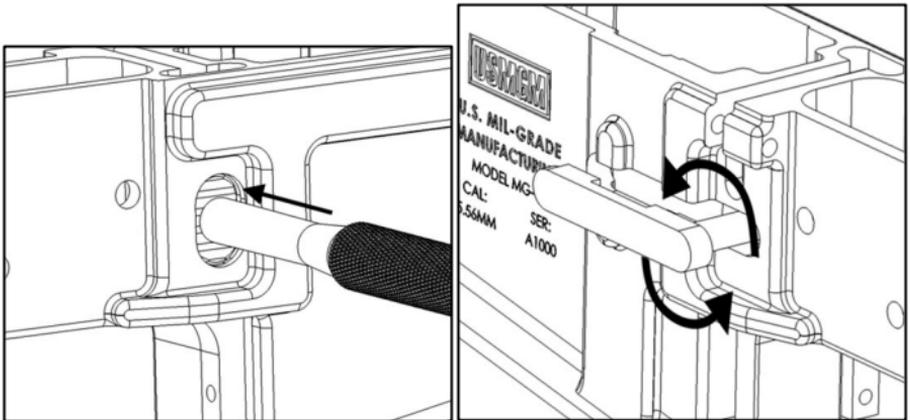
#### 4.1 DISASSEMBLY OF SAEBR SYSTEM



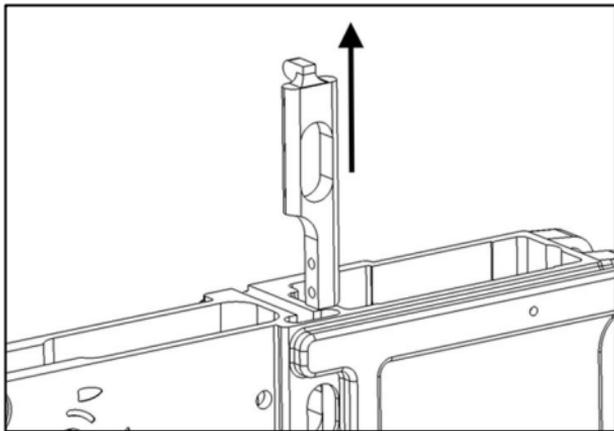
Remove the Enhanced Bolt Catch (2) by loosening the Threaded Bolt Catch Retaining Pin (3) using a 1/32 Allen wrench.



Remove the 4-40 T8 Torx Screws (6) from the aft side of the Finger Pad (5) using a T8 Torx wrench. Pull the Finger Pad (5) off the Vertical Link (4) if it is held in by friction.



Use a stick or something to fully depress the magazine button until the magazine catch clears the left side of the Receiver (1). Turn the magazine catch counter-clockwise until fully unscrewed from the magazine button. Remove the magazine button, catch, and catch spring from the Receiver (1).



Slide the Vertical Link (4) up and out of the slot in the Receiver (1).

## 4.2 REASSEMBLY OF SAEBR SYSTEM

**⚠ CAUTION:** After reassembly or any maintenance, and before live fire, perform a safe function check with the firearm unloaded and pointed in a safe direction. If any control does not operate correctly, do not fire the firearm until the issue is corrected.

To reassemble, insert the Vertical Link (4) into the machined slot in the Receiver (1). In any order, install

the Enhanced Bolt Catch (2), Finger Pad (5), and magazine catch assembly back onto the Receiver (1).

Note: The female groove on the Enhanced Bolt Catch (2) must nest with the male tooth on the Vertical Link (4). Tighten the Threaded Bolt Catch Retaining Pin (3) and the 4-40 T8 Torx Screws (6) finger-tight only – do not over-tighten. The MG-15E threaded bolt catch pin hole is partially threaded to prevent over-threading. Do not use permanent thread locker. If desired, lightly use purple 222 or blue 242 Loctite to secure loosening screws.

## 5. WARRANTY AND REPLACEMENT

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### 5.1 COVERED UNDER WARRANTY

USMGM guarantees all its products for life. Regardless of where you bought it, if a USMGM product becomes damaged or defective, we will repair or replace it at no charge to you.

### 5.2 OWNER STEPS

Fill out the USMGM warranty form (available for download at <https://www.usmilgrade.com>) and email it to [contact@usmilgrade.com](mailto:contact@usmilgrade.com).

Once approved, a service representative will send you a prepaid shipping label or a QR code for package drop-off.

Appropriately pack your item, ship it back, and USMGM will repair or replace your product.

If that model is no longer in production, USMGM will send the most similar replacement available.

\*Note: We know our gear sees tough conditions. If your item met an untimely end in an explosion, close encounter with tank tracks, withering enemy fire, etc., and is no longer in one piece, please do your best to return the majority of the item to us. For serialized items such as weapons, this must include the serialized portion of the item.

### 5.3 NOT COVERED UNDER WARRANTY

USMGM does not cover loss, theft, deliberate damage, or cosmetic damage that does not meaningfully hinder the performance of the product. If you are unsure whether your situation is covered, contact USMGM and we will work with you to make it right.

## 5.4 LEGAL NOTICE

**⚠ WARNING:** Unauthorized modification, alteration, misuse, abuse, or use with incompatible/out-of-spec components can create unsafe conditions. Such actions may void warranty coverage and may result in serious injury or death. If you have questions about compatibility or safe use, contact USMGM before proceeding.

For the purposes of this warranty, “lifetime” means the expected lifespan of the product under normal and reasonable use.

This lifetime warranty applies to the current owner of the product and is not limited to the original purchaser.

Proof that the item is an authentic USMGM product may be required.

USMGM’s liability is limited to the repair or replacement of the product at our discretion.

Serialized items such as firearms or restricted components must be returned in accordance with all applicable federal, state, and local laws.

This warranty gives you specific legal rights, and you may also have other rights which vary from state to state.

This warranty is governed by and construed under the laws of the State of Washington, without regard to conflict-of-law principles.

USMGM – Every second counts. Every choice matters. Choose the Best.

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