



# HDRY Lite

THE PRODUCT **HDRY Lite** IS SPECIFICALLY DESIGNED TO STORE YOUR FILAMENTS AT THE IDEAL HUMIDITY LEVEL.

YOU HAVE TWO DEHUMIDIFICATION OPTIONS: INSTALL A POLYDRYER OR USE A SILICA GEL BOX. ADDITIONALLY, YOU CAN INTEGRATE EITHER AN AMS SYSTEM OR A HYDRA SYSTEM INSIDE THE CASE.

IT CAN BE SET UP IN TWO CONFIGURATIONS: MOUNT IT DIRECTLY TO CREATE A SINGLE, UNIFIED VOLUME WITH THE PRINTING CHAMBER, OR USE THE EXTENDER TO SEPARATE THE TWO AREAS WITH THE PRINTER'S GLASS PANEL.

IF NEEDED, YOU CAN EASILY REMOVE THE GLASS TO RESTORE A SINGLE, HEATED CHAMBER.



PRINT TIME  
**6d 9h 18m**



ASSEMBLY  
**1h**



FILAMENT  
**4.3kg**



HERE ARE SOME SUGGESTIONS AND RESPONSES TO QUESTIONS I COMMONLY RECEIVE:

FIRST AND FOREMOST, AN IMPORTANT SUGGESTION: WHILE I UNDERSTAND THAT FILAMENT PRICES CAN SOMETIMES BE EXCESSIVELY HIGH, I STRONGLY ADVISE AGAINST USING LOW-COST FILAMENTS FOR THIS PRINT. IT NEEDS TO LAST LONG, SO USE HIGH-QUALITY FILAMENTS.

CONSIDERING THE TOLERANCES USED IN DESIGNING THIS PRODUCT, I RECOMMEND BEING CAREFUL WHEN REMOVING SUPPORTS AND DEALING WITH ANY IMPERFECTIONS FROM THE PRINTING PROCESS. IT'S CRUCIAL THAT ALL INTERLOCKING PARTS ARE SUPER CLEAN AND FREE OF DEBRIS.

WHAT MATERIAL DO YOU SUGGEST FOR PRINTING?  
I TYPICALLY USE PETG CAUSE THE HEAT RESISTANCE IS INDISPENSABLE.

A PIECE OF ADVICE I'D LIKE TO OFFER IS TO PRINT EVERYTHING AT THE STANDARD SPEED. GOING TOO FAST CAN CAUSE MATERIAL RETRACTION, WHICH COULD LEAD TO MISALIGNMENTS OF THE PIECES OR ASSEMBLY INACCURACIES.

ADDITIONALLY, IT'S IMPORTANT NOT TO REDUCE THE INFILL PERCENTAGE BELOW 10%. DOING SO MIGHT NOT PROVIDE SUFFICIENT SUPPORT FOR THE SCREW HOLES, AND THEY COULD BREAK DURING SCREW TIGHTENING.

USUALLY, I PRINT USING 2 PERIMETERS EVERYWHERE, FEW PIECES REQUIRE 3 PERIMETERS.

I UNDERSTAND THAT THE POSITIONING OF SOME PIECES ON THE PLATES MIGHT SEEM SUBOPTIMAL OR UNNECESSARILY USING SUPPORTS. IN MY DEFENSE, I CAN TELL YOU THAT QUALITY OR STRUCTURAL REASONS OBSERVED DURING PRINTING GUIDED MY CHOICES.

## REQUIRED MATERIALS:

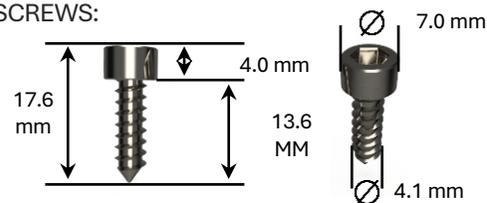
### FILAMENTS:



**PETG**

**4.3 KG**

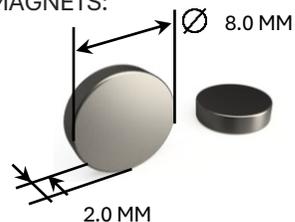
### SCREWS:



M4 12 MM  
OR  
M4 14 MM

**120 UNITS**

### MAGNETS:



**24 UNITS**

GASKET: Foam 6 X 3 MM

POLYCARBONATE SHEET: Approx. 40x40 cm

### CONSUMABLES:

- ✓ QUICK ADHESIVE
- ✓ 2 MM DOUBLE-SIDED TAPE
- ✓ BLUE TAPE
- ✓ CLEAR SILICONE

### EXTRAS:

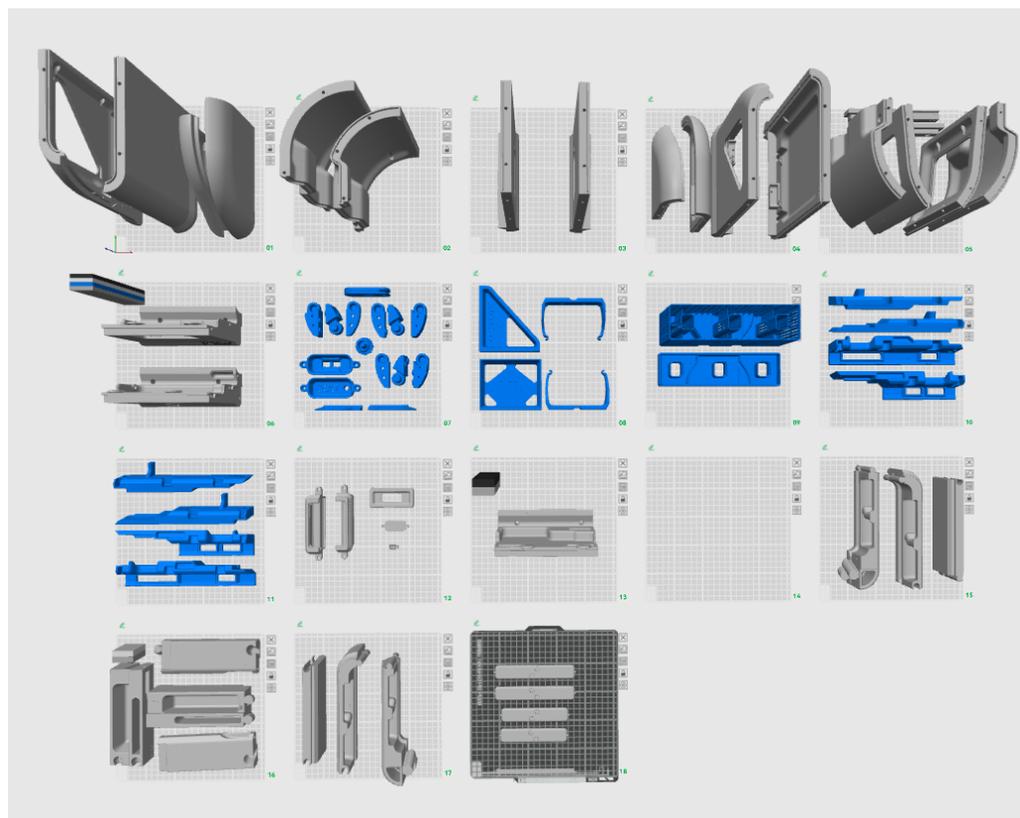


1 UNITS



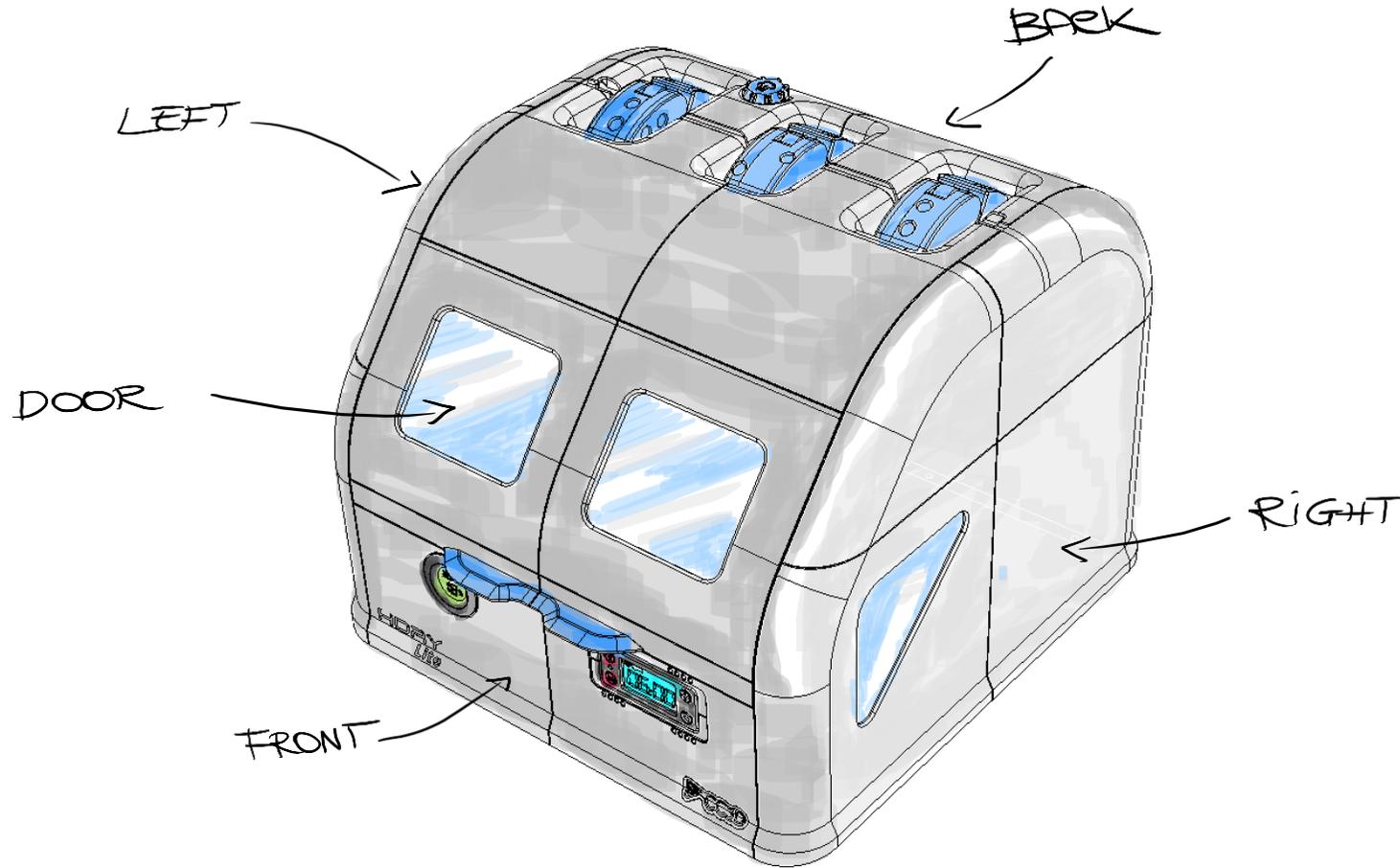
## CRUCIAL TIPS FOR SUCCESS

1. PLEASE NOTE, HAVING 2 PERIMETERS IS MORE THAN ENOUGH.
2. I RECOMMEND NOT LOWERING THE INFILL BELOW 11%, OTHERWISE, YOU RISK NOT HAVING ENOUGH MATERIAL INSIDE.
3. THE OBJECTS HAVE BEEN ORIENTED ON THE BED FOR BOTH AESTHETIC AND FUNCTIONAL REASONS. YOU'RE FREE TO REPOSITION THEM AS YOU LIKE, BUT BE MINDFUL OF THE NECESSARY SUPPORTS.



# Main body overview

HDRY Lite's MAIN BODY IS ESSENTIALLY  
MADE UP OF 5 SUB-ASSEMBLIES.



# Left side assembly

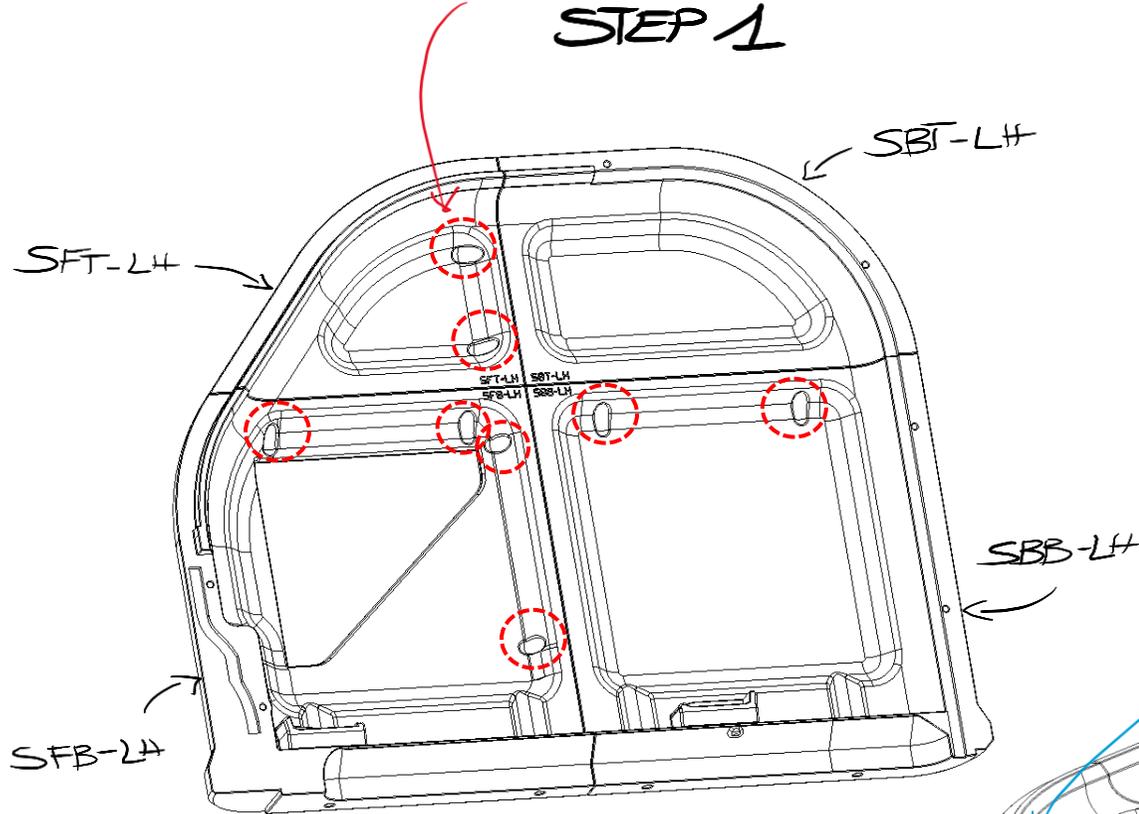


## REQUIRED HARDWARE

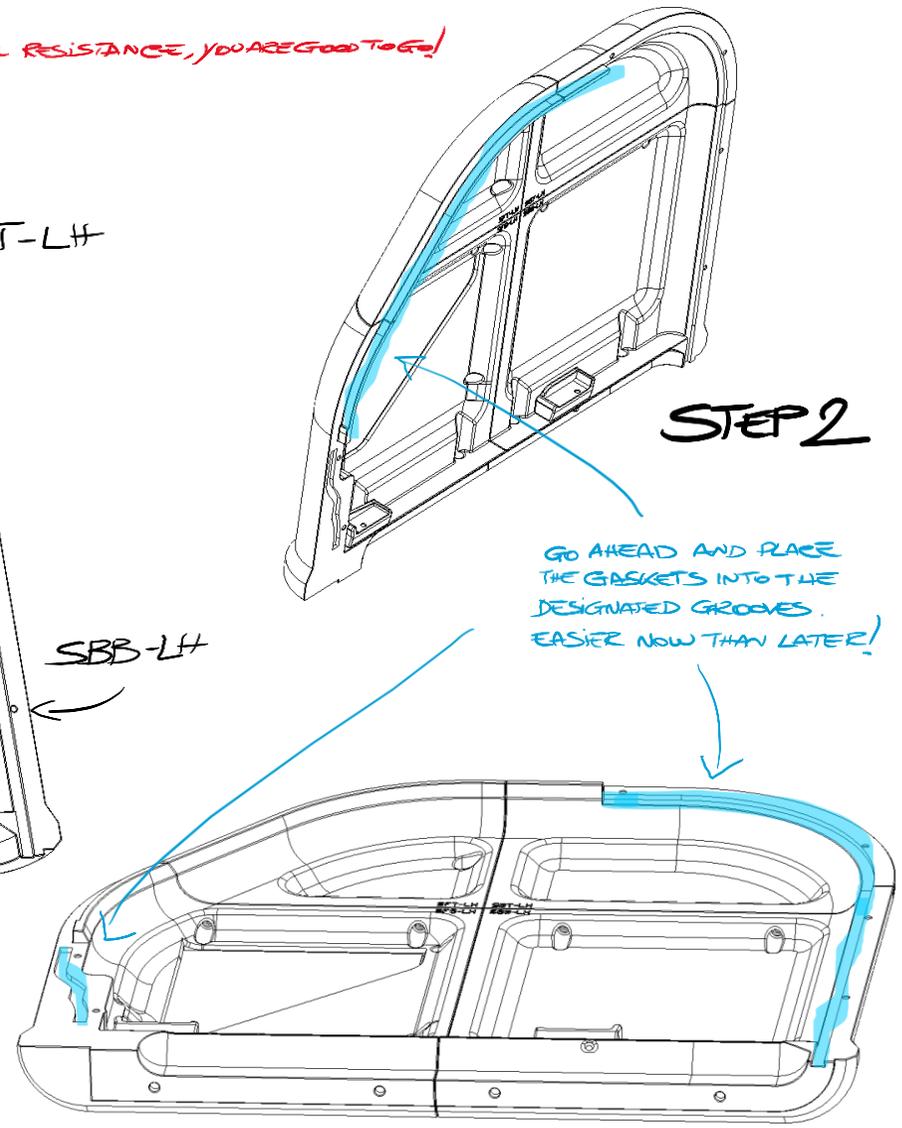
SCREWS 8

INSERT THE SCREWS INTO THE HOLES MARKED IN RED AND TIGHTEN THEM.  
JUST DON'T OVERDO IT - ONCE YOU FEEL RESISTANCE, YOU ARE GOOD TO GO!

### STEP 1



### STEP 2



# Back side assembly

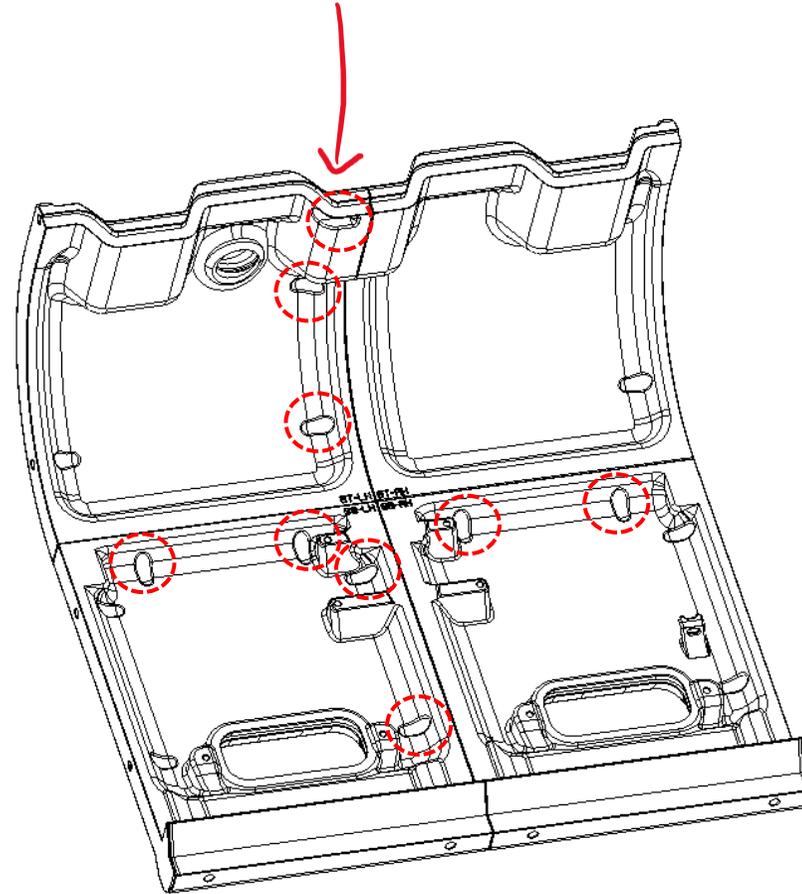


## REQUIRED HARDWARE

SCREWS 9

INSERT THE SCREWS INTO THE HOLES MARKED IN RED AND TIGHTEN THEM.

JUST DON'T OVERDO IT - ONCE YOU FEEL RESISTANCE, YOU ARE GOOD TO GO!



# Right side assembly

## REQUIRED HARDWARE

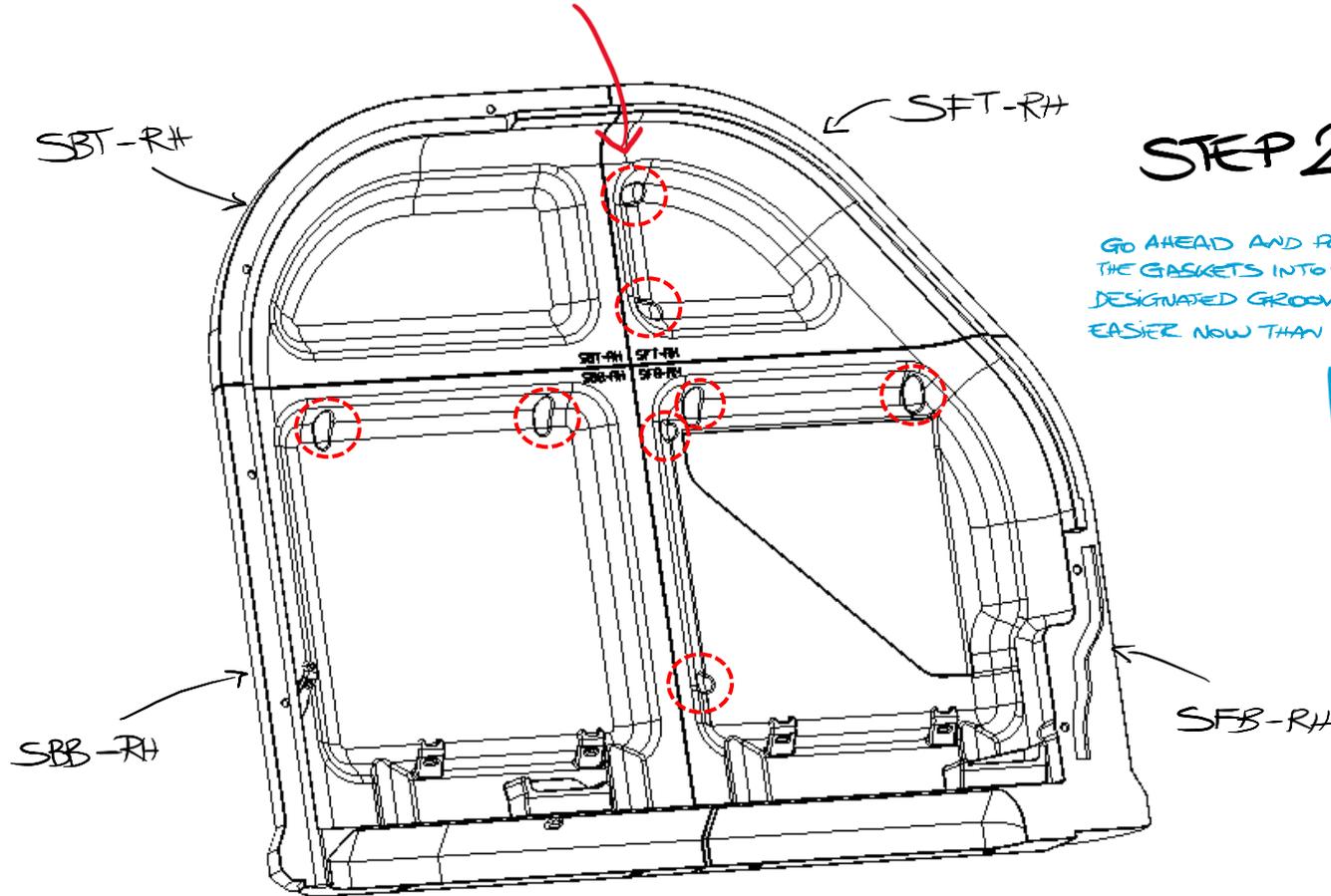
SCREWS 8

GASKET

## STEP 1

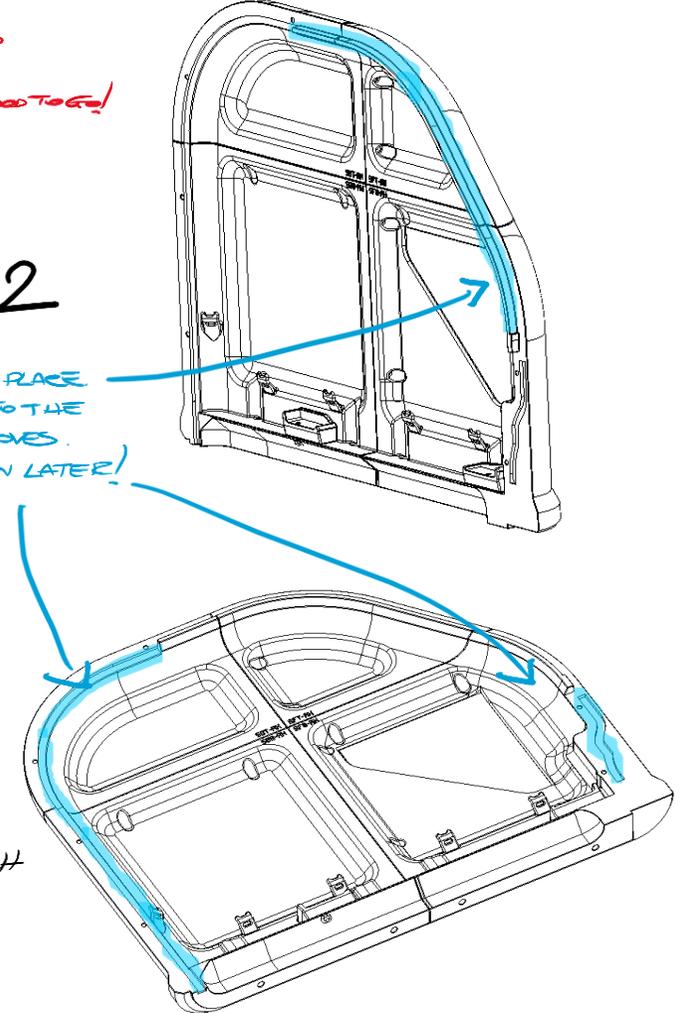
INSERT THE SCREWS INTO THE HOLES MARKED IN RED AND TIGHTEN THEM.

JUST DON'T OVERDO IT - ONCE YOU FEEL RESISTANCE, YOU ARE GOOD TO GO!



## STEP 2

GO AHEAD AND PLACE THE GASKETS INTO THE DESIGNATED GROOVES. EASIER NOW THAN LATER!



# Door assembly

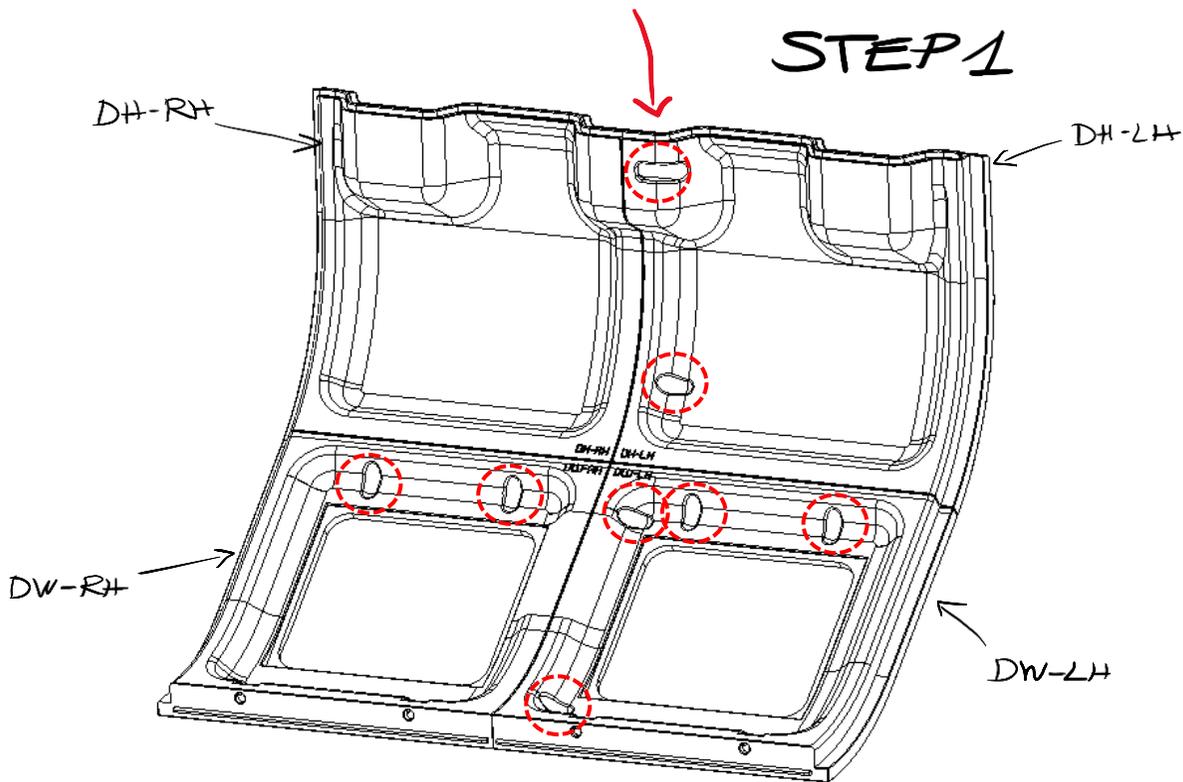
## REQUIRED HARDWARE

SCREWS 12  
GWE

INSERT THE SCREWS INTO THE HOLES MARKED IN RED AND TIGHTEN THEM.

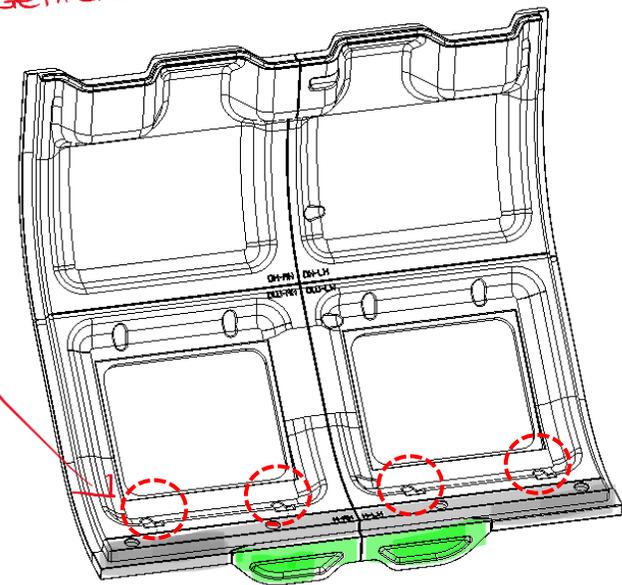
JUST DON'T OVERDO IT - ONCE YOU FEEL RESISTANCE, YOU ARE GOOD TO GO!

### STEP 1

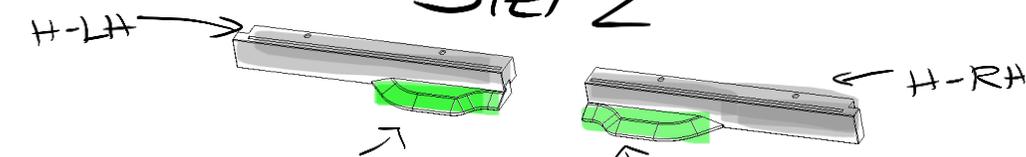


### STEP 3

BRING THE 2 HANDLES CLOSE TO THE DOOR SECTION AND FASTEN THEM TOGETHER USING THE SCREWS MARKED IN RED!



### STEP 2



GLUE THE PART HIGHLIGHTED IN GREEN TO THE ONES IN GRAY, I USED QUICK-DRYING GLUE!

# Front side assembly

## REQUIRED HARDWARE

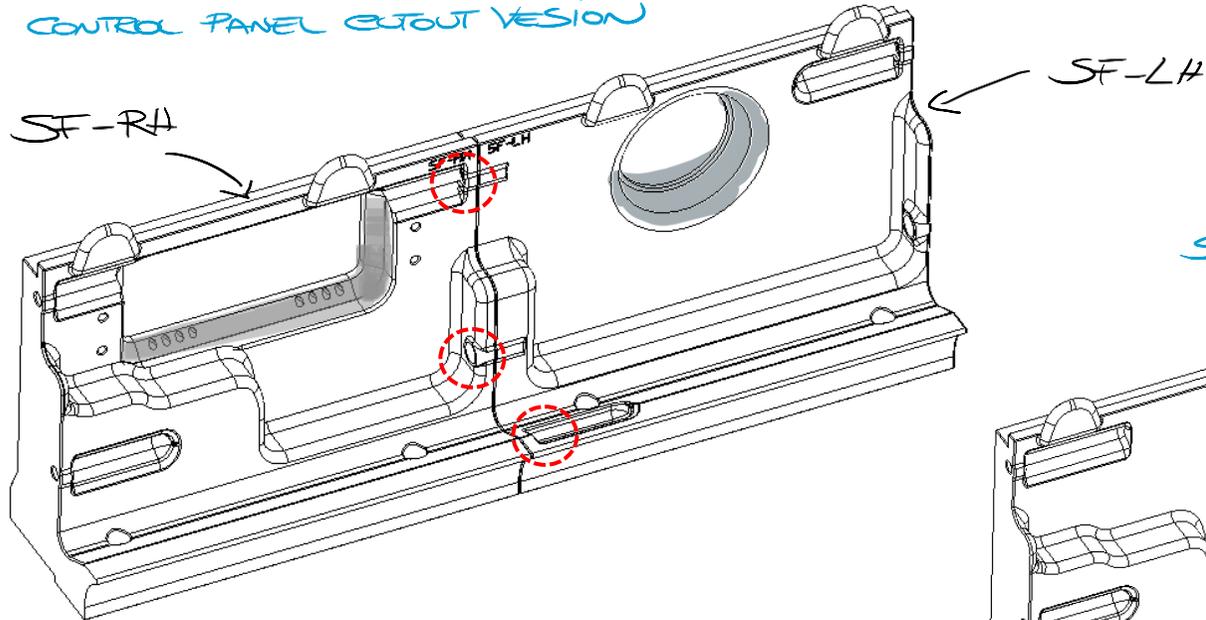
SCREWS 3

KEEP IN MIND THAT YOU HAVE TWO FRONT AVAILABLE:

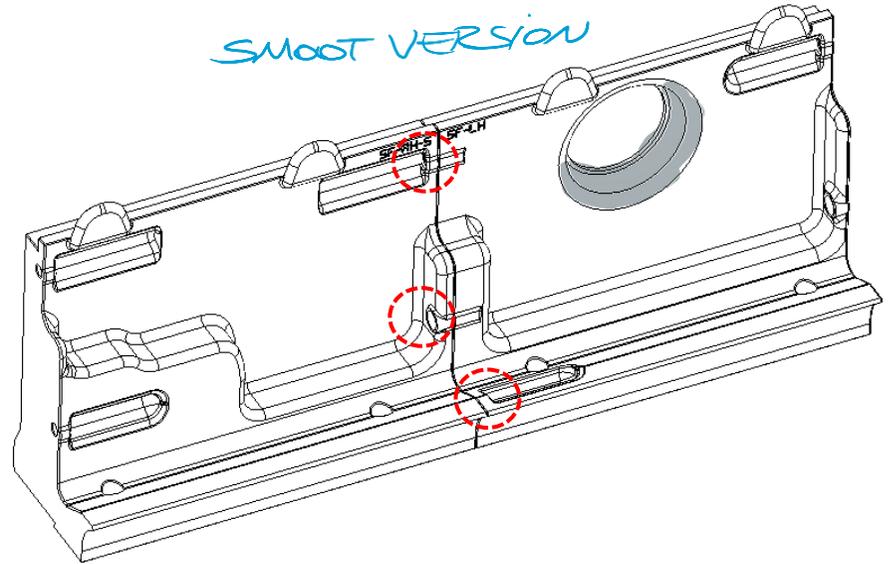
ONE WITH DRYER CONTROL PANEL  
AND ONE WITHOUT SO SMOOTH!

INSERT THE SCREWS INTO THE HOLES MARKED IN RED  
AND TIGHTEN THEM.

CONTROL PANEL OUTOUT VERSION



SMOOTH VERSION



\* SAME SCREW NUMBER  
\* SAME MOUNTING HOLES

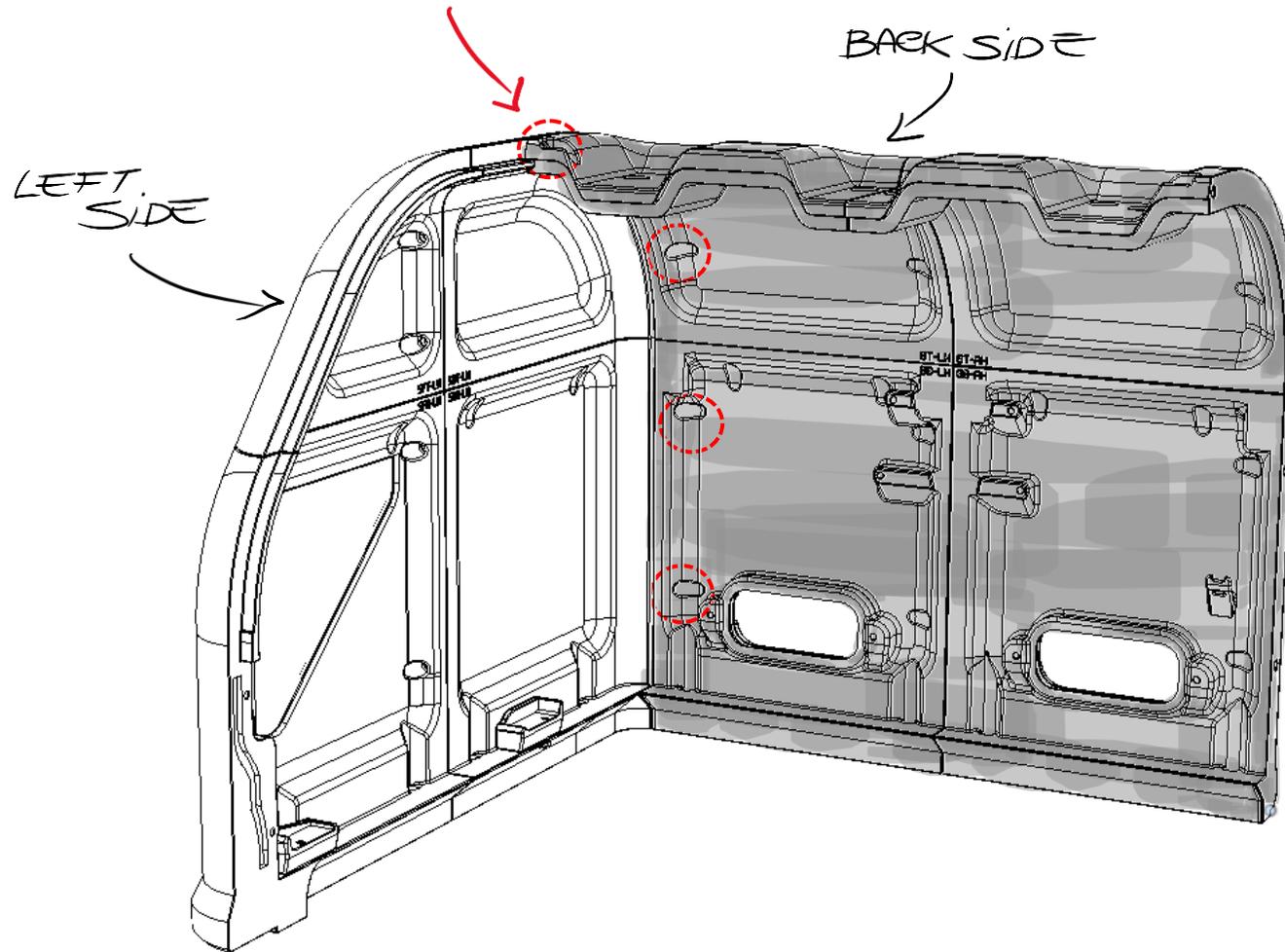
# Main BODY assembly

REQUIRED HARDWARE

SCREWS 4

HERE WE GO, LET'S START ASSEMBLING  
THE MAIN BODY!

INSERT THE SCREWS INTO THE HOLES MARKED IN RED  
AND TIGHTEN THEM.



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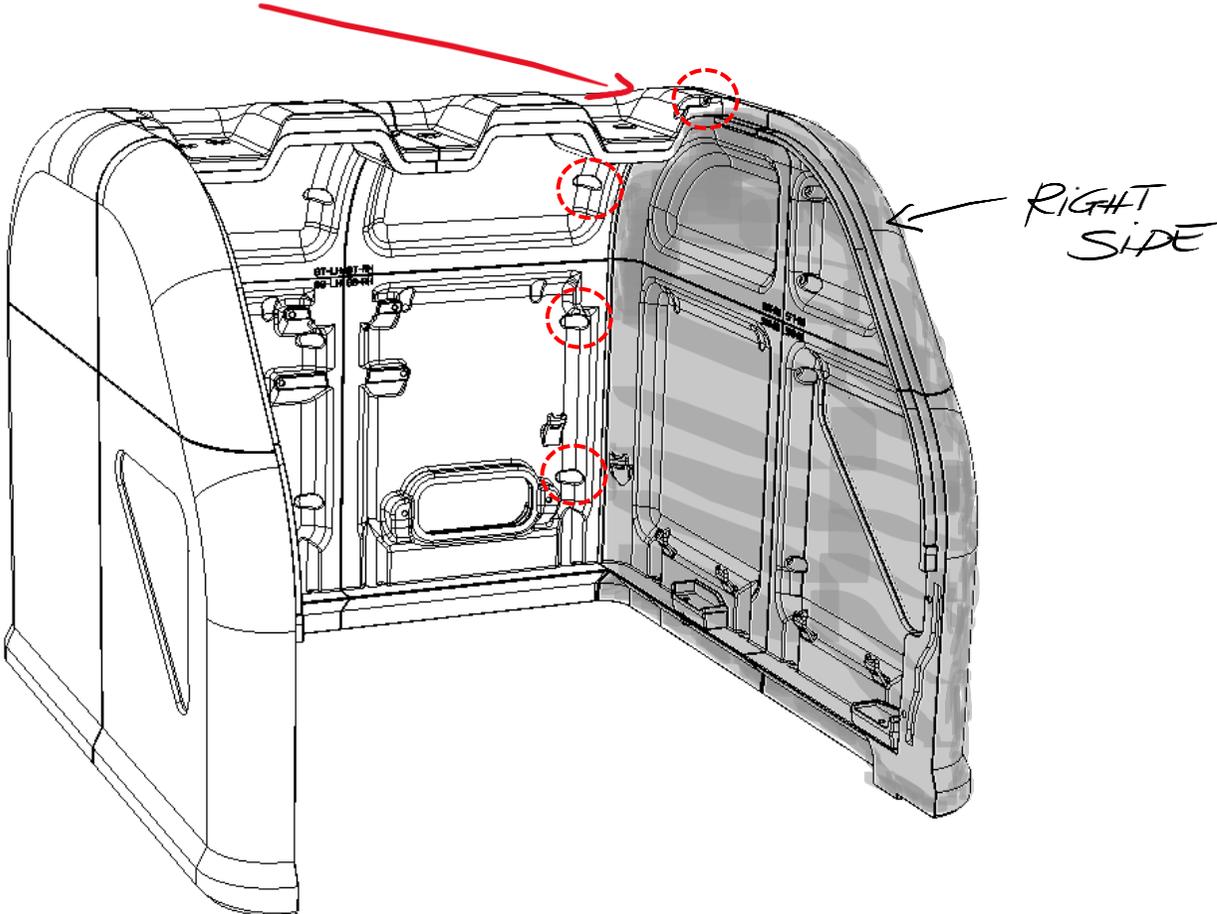
# Main BODY assembly



## REQUIRED HARDWARE

SCREWS 4

INSERT THE SCREWS INTO THE HOLES MARKED IN RED AND TIGHTEN THEM.



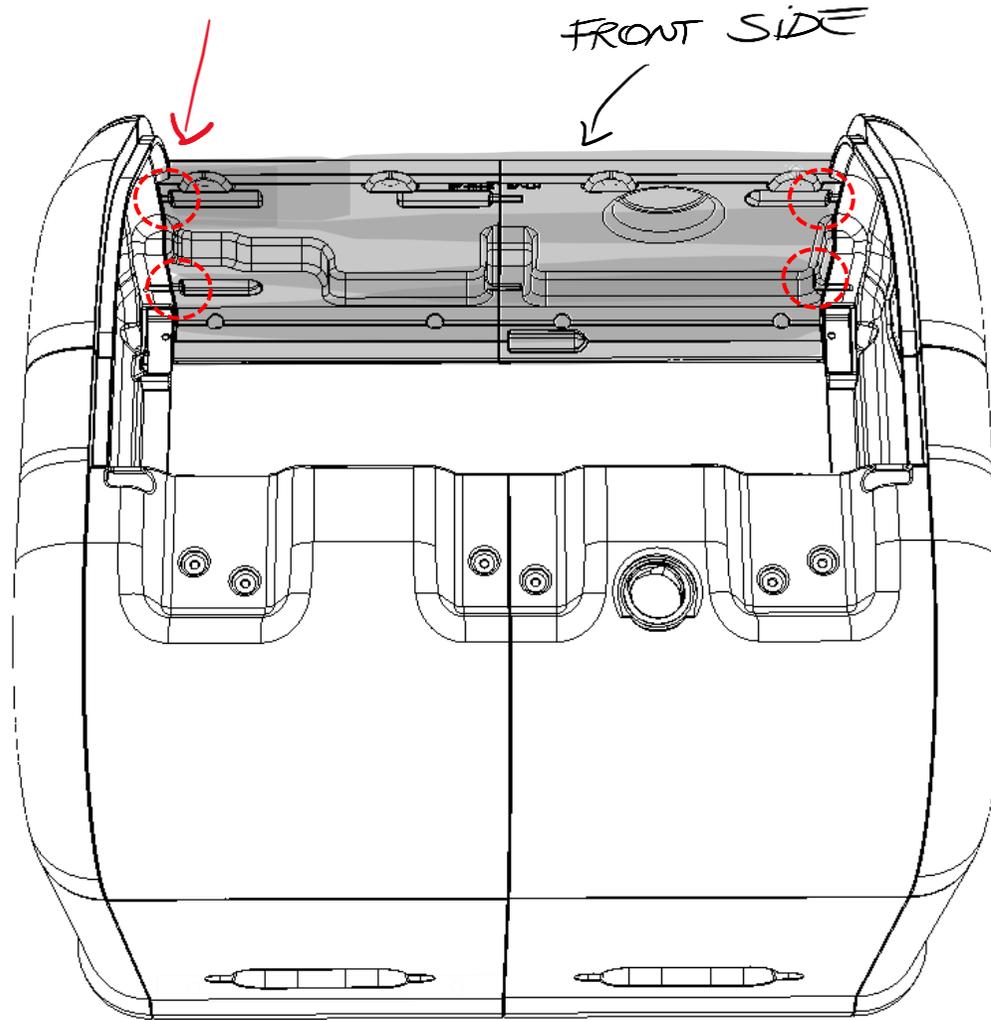
# Main BODY assembly



REQUIRED HARDWARE

SCREWS 4

INSERT THE SCREWS INTO THE HOLES MARKED IN RED AND TIGHTEN THEM.



HERE'S THE RIGHT SIDE

HERE'S THE LEFT SIDE

MAIN BODY TOP & REAR VIEW!

THIS IS THE BACK

# Main BODY assembly

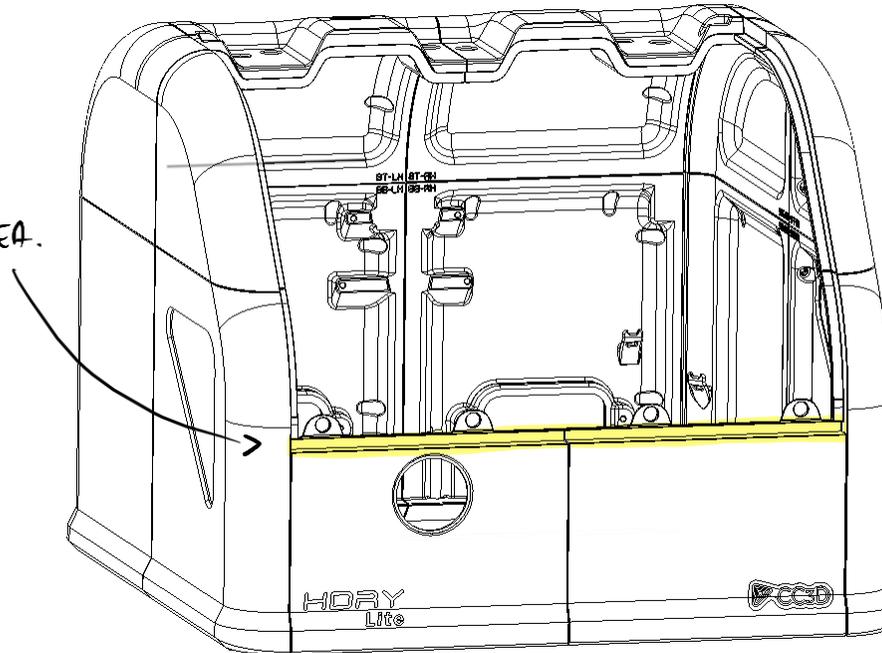
REQUIRED HARDWARE

GASKET

NEXT...

YOU NEED TO INSTALL A  
PIECE OF GASKET IN THIS AREA.

IT'S ESSENTIAL FOR SEALING  
THE DOOR PROPERLY.



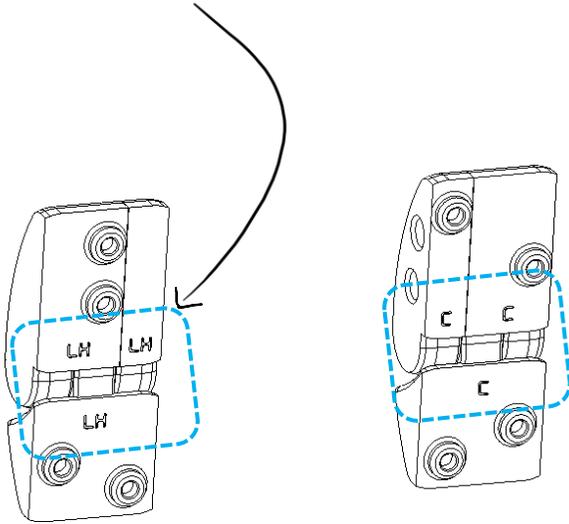
# HINGE assembly

## REQUIRED HARDWARE

- SCREWS 6
- GREASE DROPS

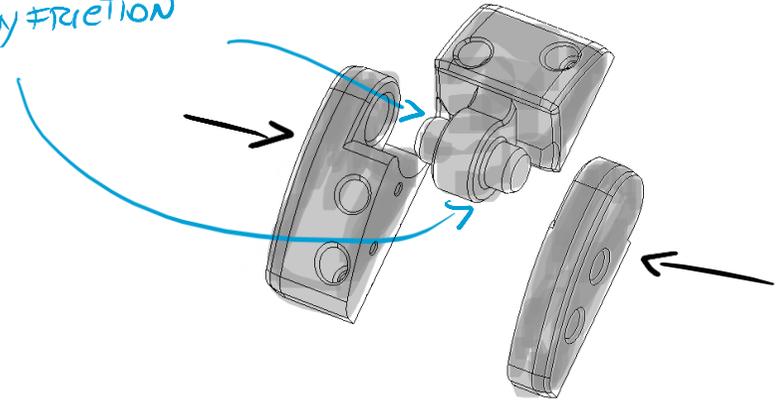
TIME TO ASSEMBLE THE DOOR HINGES!

EACH HINGE TO HELP YOU  
TELL THEM APART

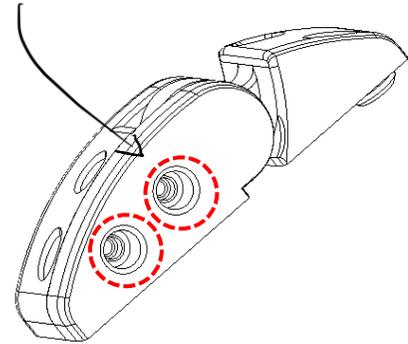


\* I SUGGEST APPLYING A TOUCH OF  
GREASE TO PREVENT ANY FRICTION

ATTACH THE PIECES  
LIKE THIS



INSERT TWO SCREWS INTO THE MARKED HOLES  
AND TIGHTEN THEM - JUST DON'T OVERDO IT!



REPEAT THIS PROCESS 3 TIMES  
AND YOU ARE GOOD TO GO!

# Main BODY assembly



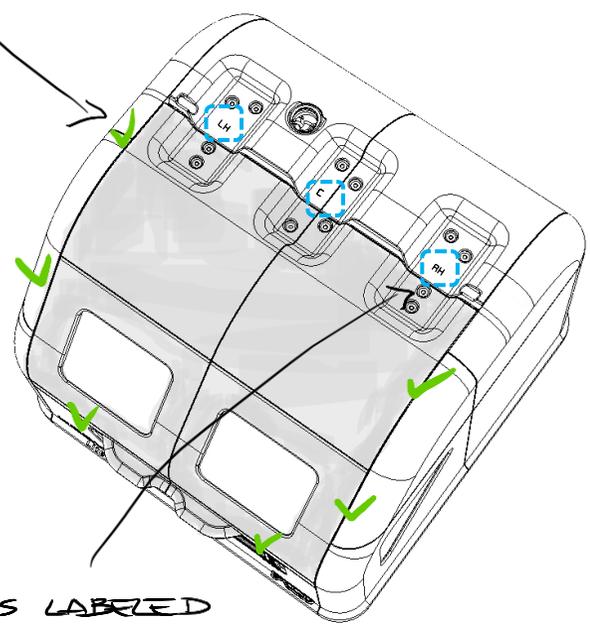
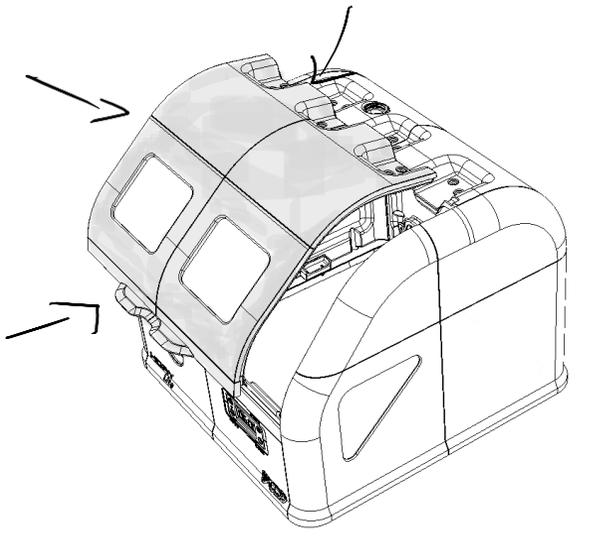
REQUIRED HARDWARE

LET'S INSTALL THE DOOR ON YOUR HDRY LIFE.

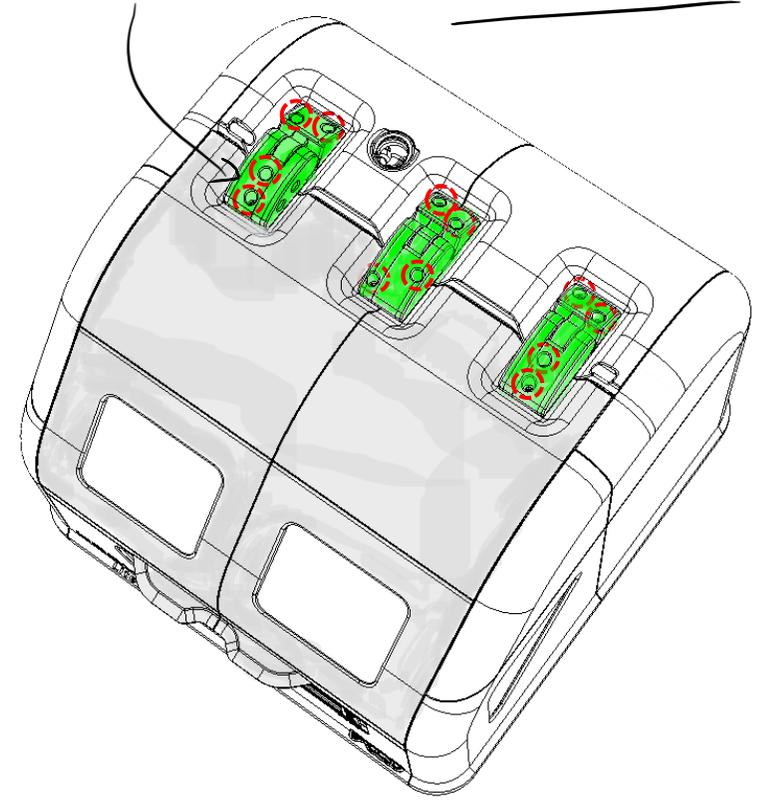
SCREWS 12

NOW, ONE SCREW INTO EACH HIGHLIGHTED HOLE AND TIGHTEN THEM, JUST DON'T OVERDO IT!

PLACE THE DOOR SO IT REST PERFECTLY ON THE GASKETS AND LINE UP WITH THE EDGES OF THE SIDE PANEL.



EACH SLOT IS LABELED WITH THE MATCHING HINGE CODE, SO IT'S EASY TO ALIGN EVERYTHING.



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# Main BODY assembly

REQUIRED HARDWARE

MAGNET 8

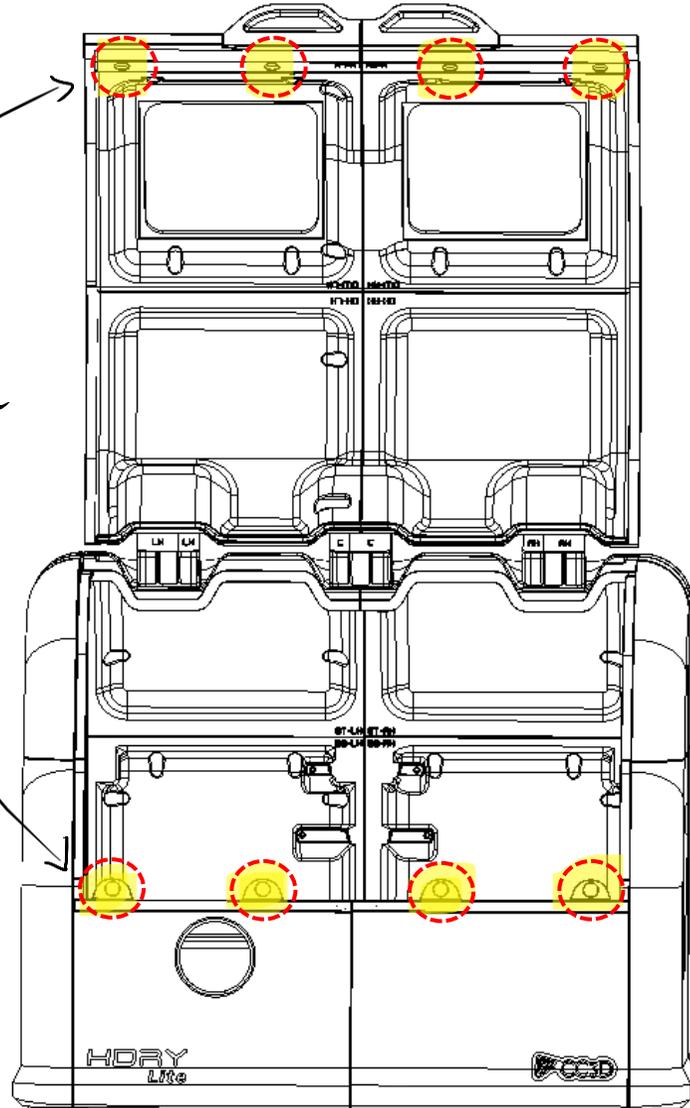
NOW, LET'S INSTALL THE MAGNETS NEEDED TO KEEP THE DOOR CLOSED

YOU'LL NEED:

4 MAGNETS FOR THE DOOR  
4 MAGNETS FOR THE FRONT  
PANEL

BE SURE TO CHECK THE  
POLARITY CAREFULLY.

USE QUICK ADHESIVE WITH  
AN ACTIVATOR SPRAY FOR A  
STRONG BOND.

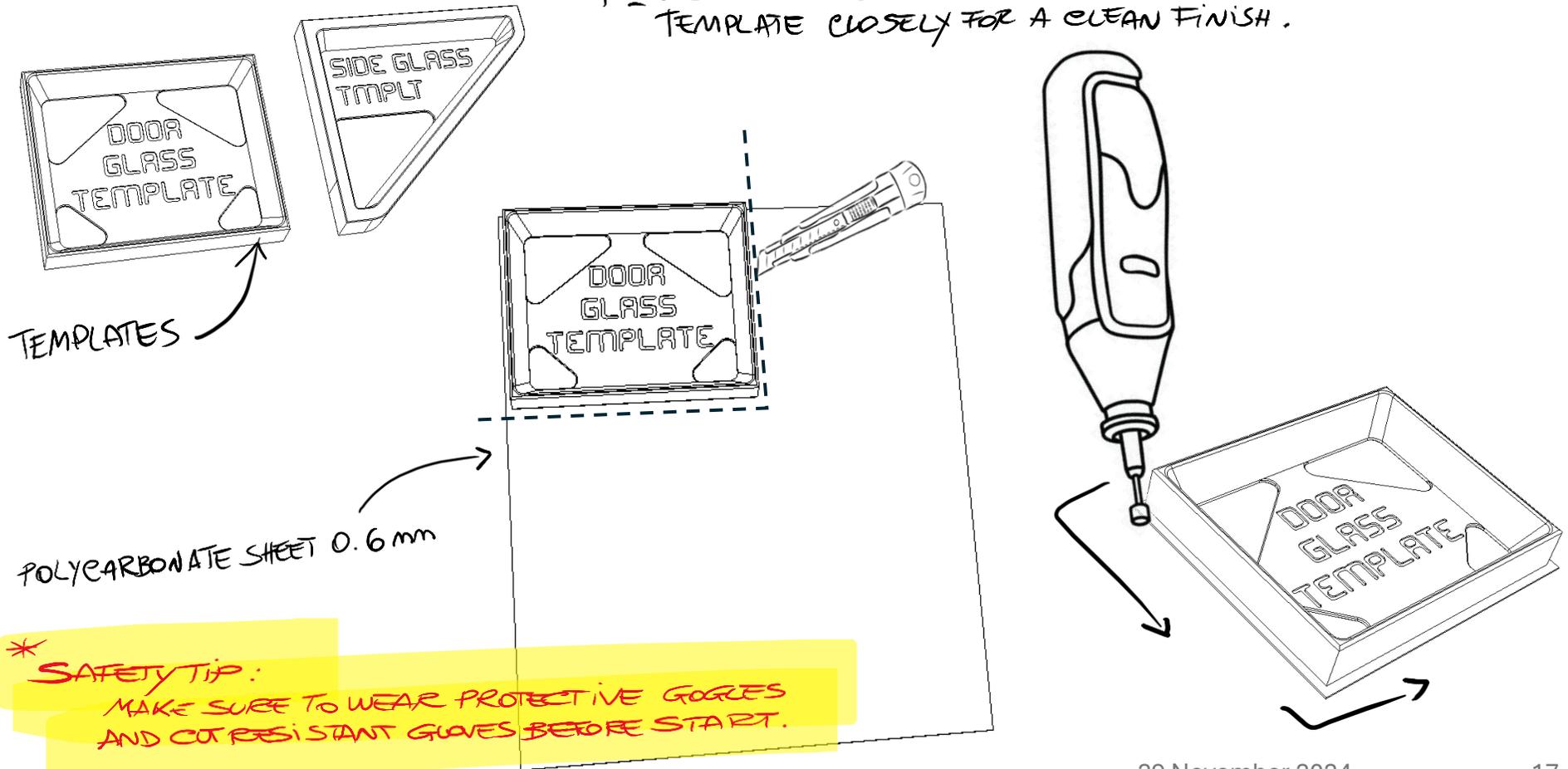


# Main BODY assembly

REQUIRED HARDWARE  
DOUBLE-SIDED TAPE  
CUTTER  
DREMEL STYLE DRILL

LET'S CREATE THE GLASS FOR THE HDRYlite.

- 1- GET A TRANSPARENT PANEL: I USED A POLYCARBONATE PANEL FROM PHOTOFRAMES, LIKE IKEA-STYLE OR FRAMELESS ONE WITH METAL CLIPS.
- 2- APPLY DOUBLE-SIDED TAPE ON THE TEMPLATE AND IT ONTO THE TRANSPARENT PANEL.
- 3- USE A CUTTER TO CUT ALONG THE TEMPLATE. PRECISION ISN'T CRITICAL AT THIS STAGE
- 4- USE A DREMEL TO SMOOTH THE EDGES AND FOLLOW THE TEMPLATE CLOSELY FOR A CLEAN FINISH.



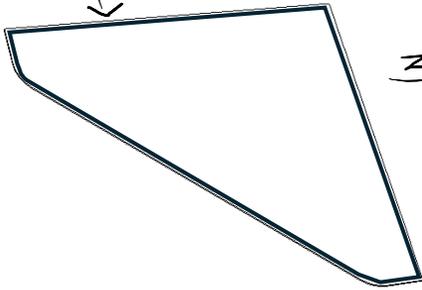
# Main BODY assembly

## REQUIRED HARDWARE

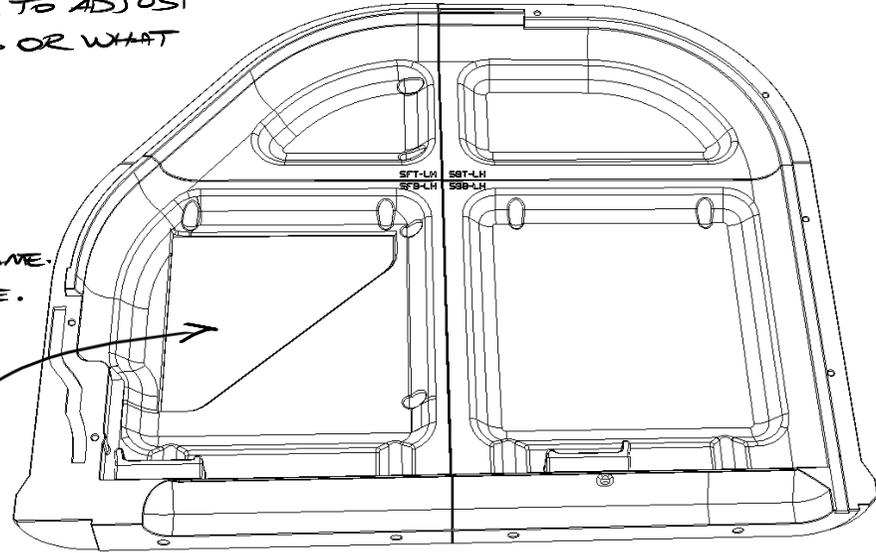
- DOUBLE-SIDED TAPE
- BLUETAPE
- SILICONE

HOW TO INSTALL THE GLASSES TO THE FRAMES?  
HERE IS HOW I DID IT, FEEL FREE TO ADJUST  
BASED ON YOUR PREFERENCES OR WHAT  
WORKS BEST FOR YOU

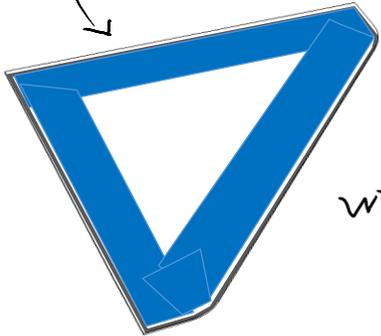
1 - APPLY 2mm DOUBLE-SIDED TAPE ALONG THE  
EDGE OF THE GLASS THAT WILL ATTACH TO THE FRAME.  
THIS HELP TEMPORARLY HOLD THE GLASS IN PLACE.



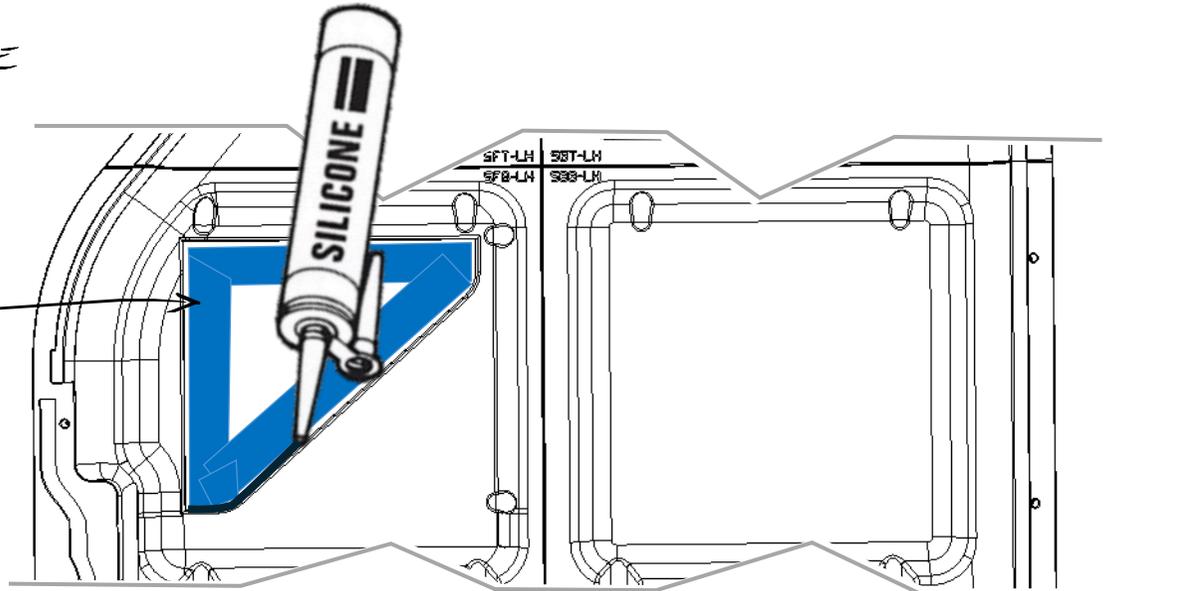
3 - POSITION THE GLASS  
ONTO THE FRAME.



2 - MASK THE OPPOSITE SIDE OF THE  
GLASS, LEAVING 2mm FROM THE  
BORDER AROUND.



4 -  
SEAL THE EDGES  
WITH CLEAR SILICONE.



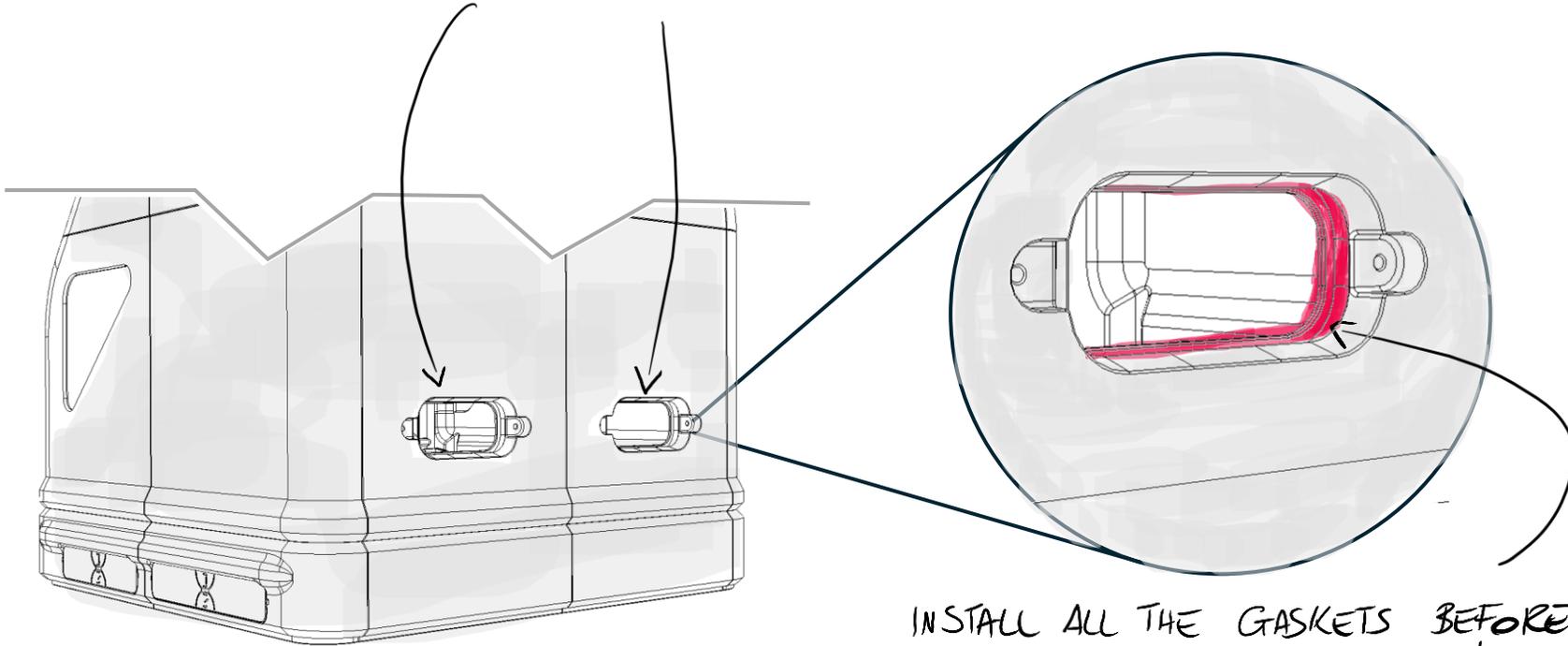
# Main BODY assembly

## REQUIRED HARDWARE

GASKET

NOW LET'S FOCUS ON THE REAR SECTION OF THE HDRY.  
WE'LL BE INSTALLING THE REAR CAPS.

EACH REAR HOLE FEATURES A GROOVE FOR THE GASKETS



INSTALL ALL THE GASKETS BEFORE  
MOVING TO THE NEXT STEP!

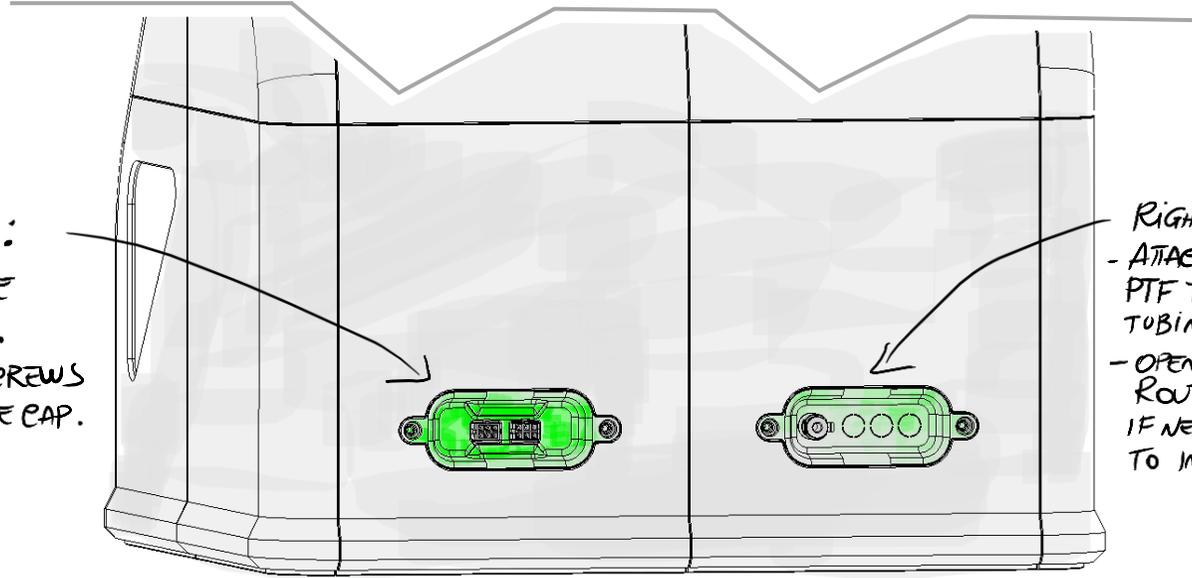
# Main body overview

## REQUIRED HARDWARE

SCREWS 4

MOVING ON TO THE CAPS NOW!

I'VE POSITIONED THE CAPS IN THIS WAY, BUT YOU ARE FREE TO SWAP THEM AS YOU LIKE - IT ALL DEPENDS ON WHERE YOU PREFER EACH ONE TO GO.



### LEFT CAP INSTALLATION:

- THIS CAP FOR ROUTING THE AMS CONNECTOR OUTSIDE.
- USE THE ORIGINAL AMS SCREWS TO SECURE THE SOCKET TO THE CAP.

### RIGHT CAP:

- ATTACH A QUICK CONNECTOR FOR PTF TUBE M10, AND PASS-THROUGH TUBING.
- OPEN THE PRE-CUT HOLES TO ROUTE THE DRYER CABLE AND IF NEEDED, ANY LEDs YOU PLAN TO INSTALL.

### NOTE:

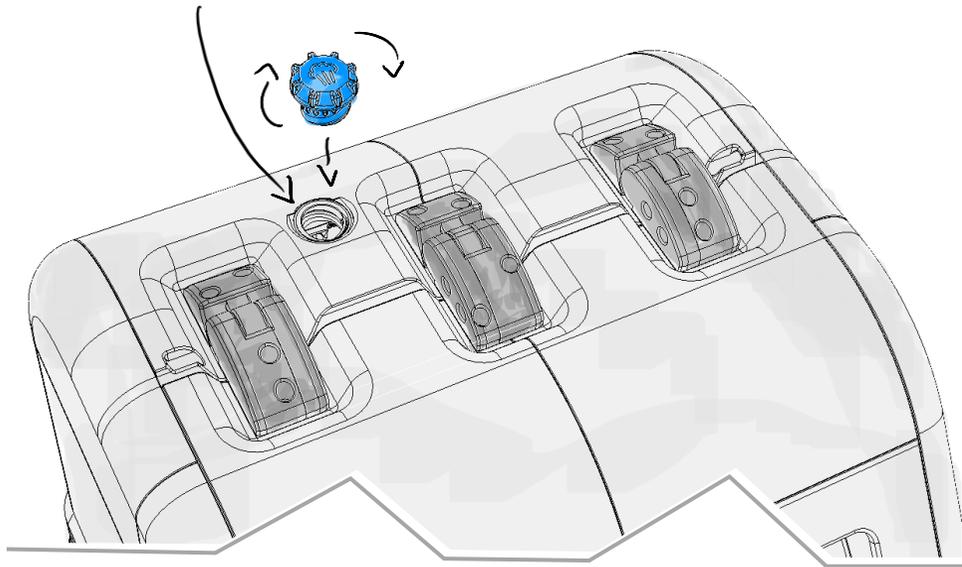
THE CABLES CONNECTING THE AMS TO ITS PLUG MAY NOT BE LONG ENOUGH. IF THAT'S THE CASE, YOU'LL NEED TO EXTEND THEM SLIGHTLY, BUT DON'T WORRY IT'S A STRAIGHTFORWARD TASK!

# Main BODY assembly

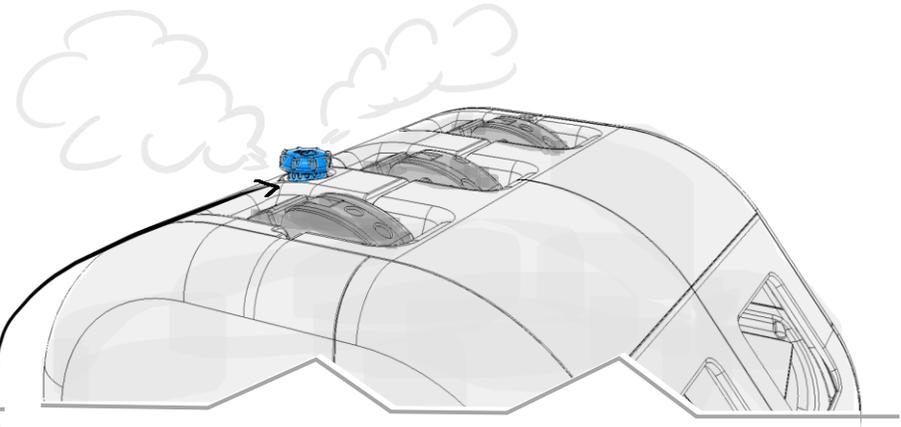
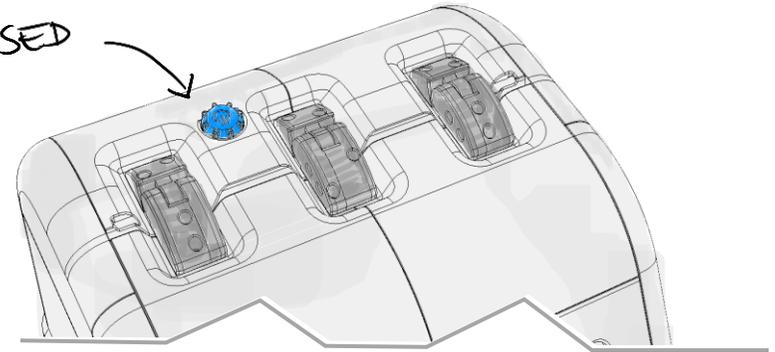
REQUIRED HARDWARE

NOW IT'S TIME TO INSTALL MY FAVORITE PART OF THIS MODEL:  
THE STEAM-RELEASE CAP.

SIMPLY SCREW THE CAP  
INTO DESIGNATED HOLE



FULLY CLOSED



TO OPEN IT, JUST TWIST IT HALF A TURN COUNTERCLOCKWISE.  
THIS WILL REVEAL SMALL OPENINGS IN THE CAP, ALLOWING  
ANY STEAM IN THE HEATED CHAMBER TO ESCAPE

# Main BODY assembly

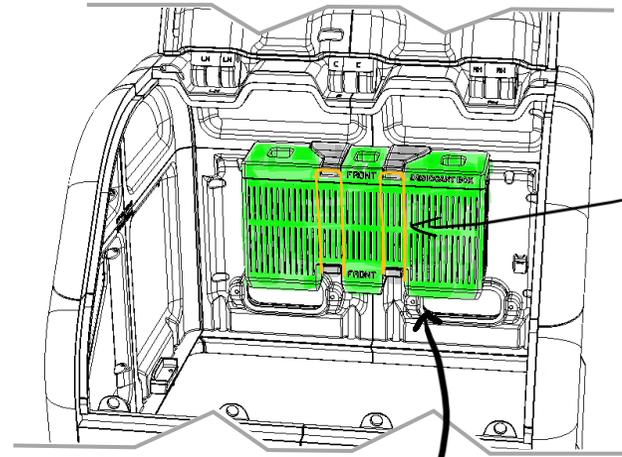
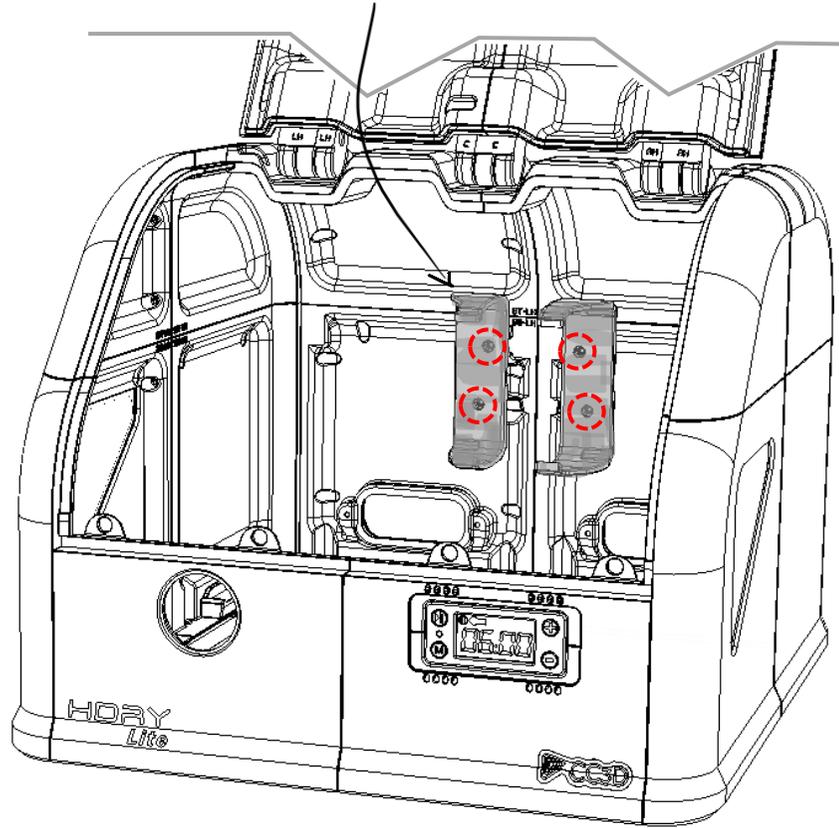


## REQUIRED HARDWARE

- SCREWS 4
- RUBBER BAND 2

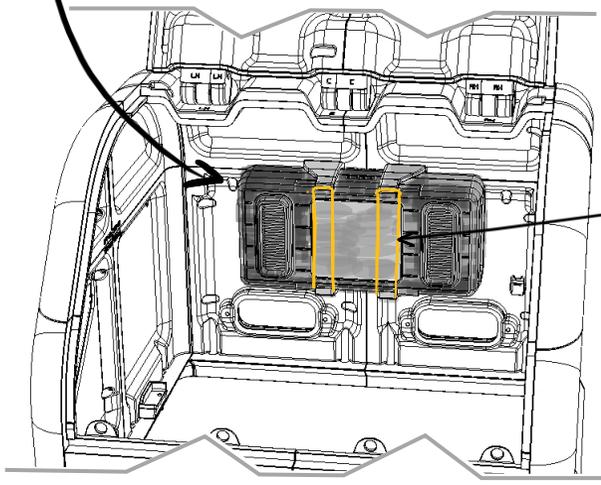
LET'S INSTALL INNER SUPPORT FOR THE DRYER OR THE DESICCANT BOX.

POSITION THE SUPPORTS CORRECTLY AND SECURE THEM WITH SCREWS.



RUBBER BANDS

NOW IT'S YOUR CALL:  
DRYER or DESICCANT GEL?  
WHAT WILL IT BE?

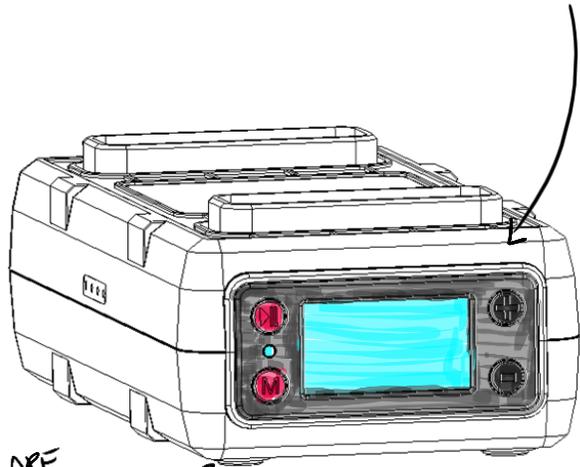


RUBBER BANDS

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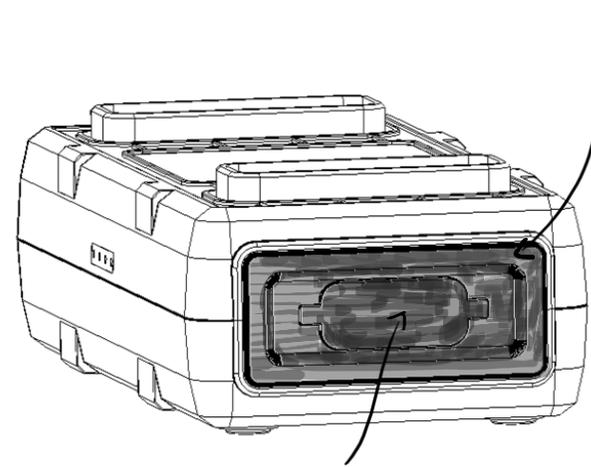
LET'S GET THE DRYER READY BY MOVING ITS CONTROL PANEL TO THE FRONT OF THE #DRY like.

OPEN THE DRYER REMOVING THE 4 SCREWS AT THE BOTTOM AND DISCONNECT THE PANEL.



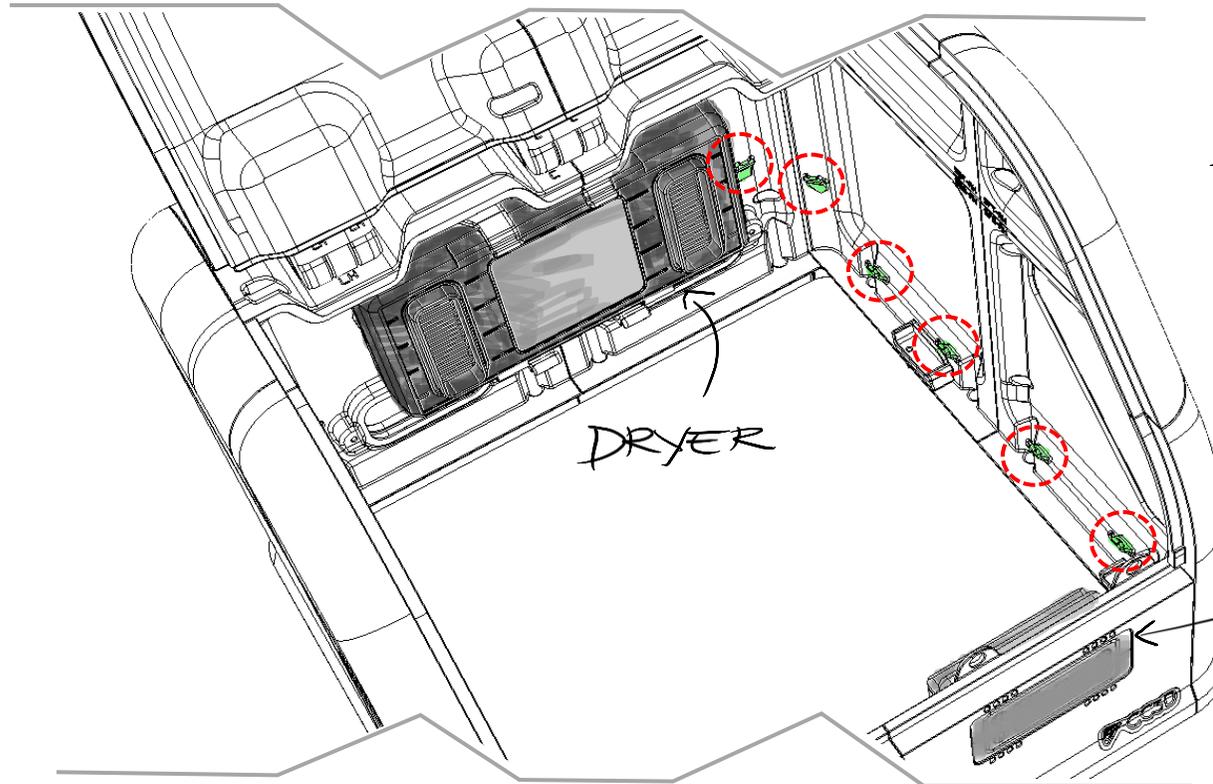
THE 4 SCREWS ARE LOCATED ON THIS SIDE

ATTACH THE NEW PANEL TO SEAL THE HOLE AND REASSEMBLE THE DRYER.



CREATE A HOLE IN THE TPU CAP FOR THE NEW CABLE TO PASS THROUGH, THEN SECURE THE CAP TO THE PANEL.

IF YOU GO WITH THE OPTION THAT PLACE THE DRYER PANEL ON THE FRONT, YOU'LL NEED TO EXTEND THE CONNECTION CABLE FIRST.



RUN THE CABLE THROUGH THE HIGHLIGHTED SUPPORTS  
MAKE SURE TO INSULATE THE CABLES PROPERLY WITH A PROTECTIVE SLEEVE,  
AND SECURE THEM TO THE STRUCTURE USING STANDARD ZIPTIES.

Any modifications or alterations to the electrical components are made at the user's own risk. I am not responsible for any damages, malfunctions, or safety hazards resulting from changes to the electrical parts. Always consult a certified professional for such modifications.

# DRYER Installation

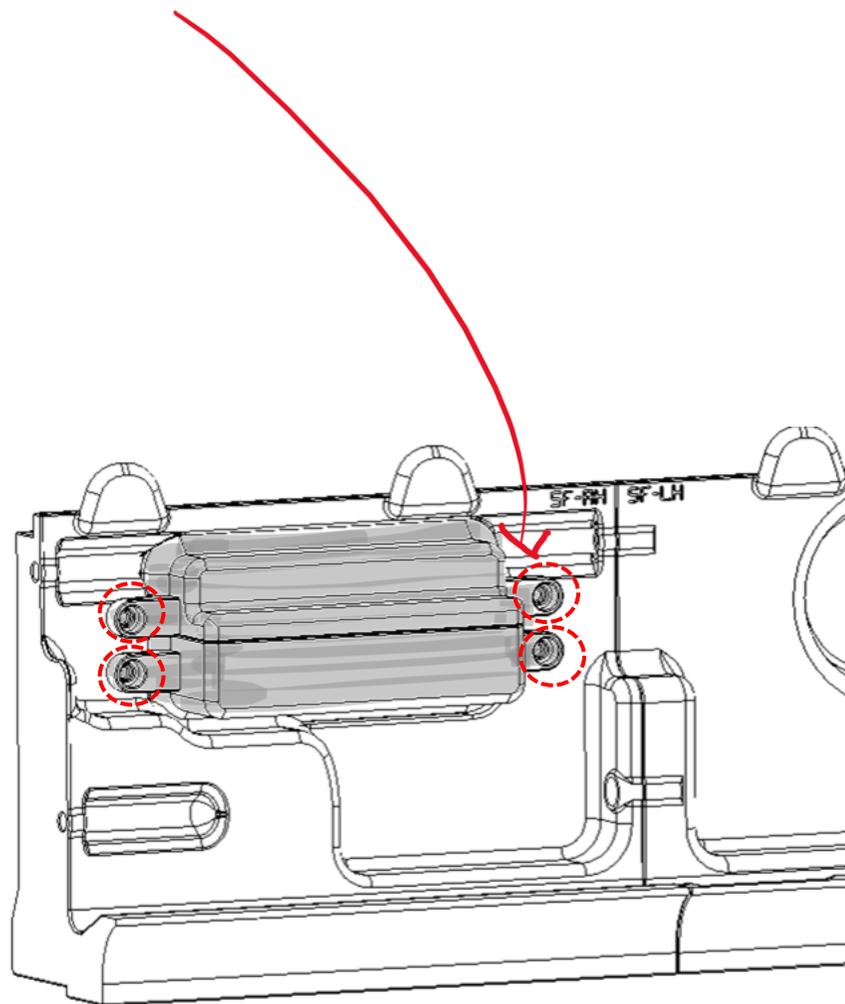
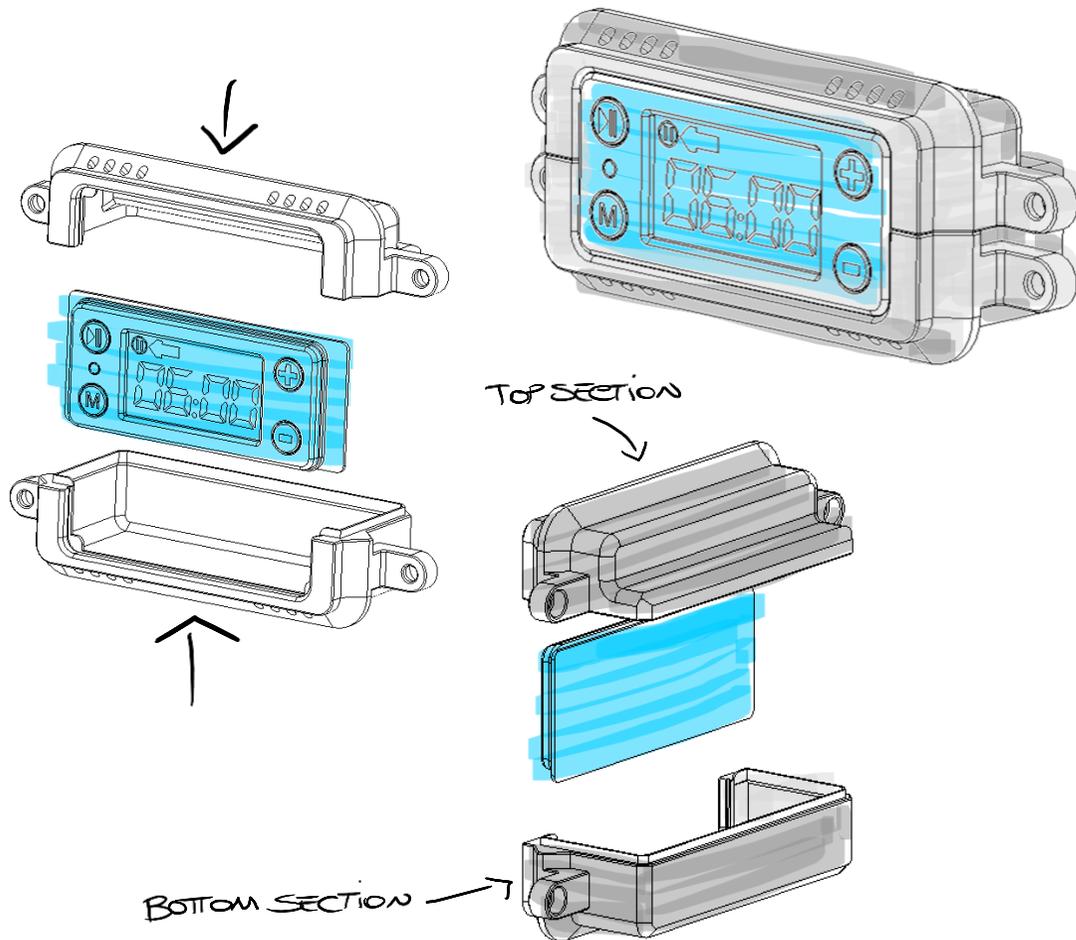


## REQUIRED HARDWARE

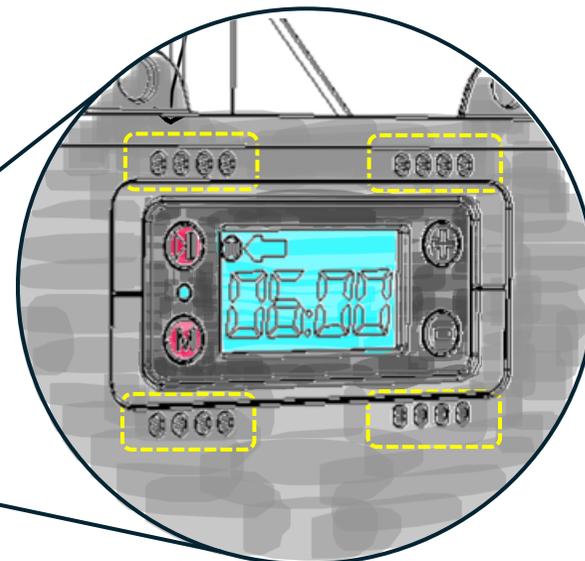
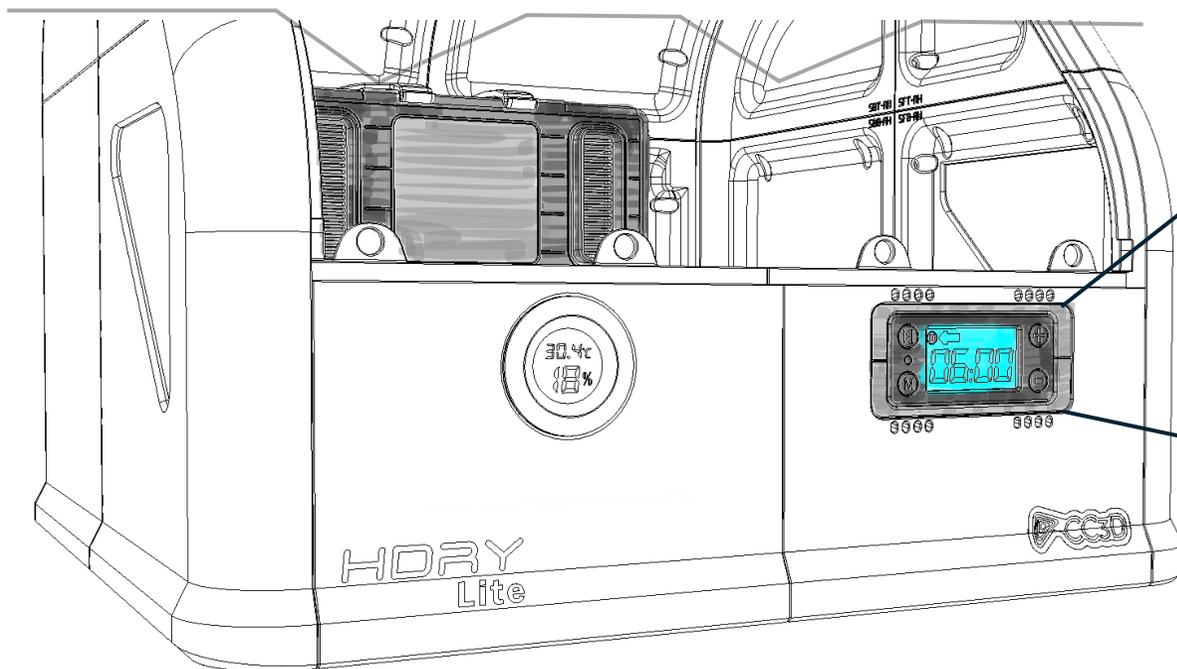
SCREWS 4

HERE'S HOW TO ASSEMBLE THE DRYER CONTROL PANEL BOX.  
SIMPLY INSERT THE PANEL INTO THE DESIGNATED BRACKETS AND BRING THE PIECES TOGETHER UNTIL THEY SNAP INTO PLACE.  
NO GWE OR SCREWS ARE NEEDED NOW!

LATER, YOU'LL USE 4 SCREWS TO SECURE IT TO THE FRONT PANEL



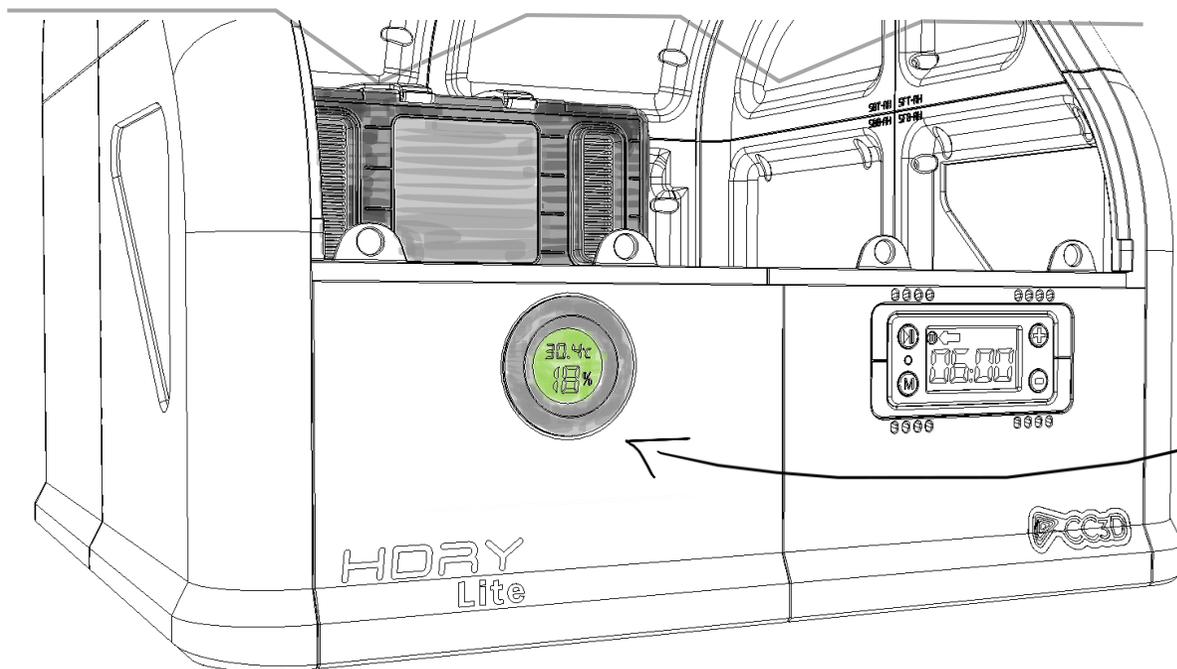
OH, ALMOST FORGOT... THE HIGHLIGHTED HOLES ARE THERE TO HELP VENTILATE THE ELECTRONIC IN THE CONTROL PANEL, A CLASSY TOUCH FROM SOMEONE WHO FRYED A DRYER BY SKIPPING THIS STEP!



# DRYER Installation



WHICH SENSOR SHOULD I BUY?  
THERE ARE PLANTY AVAILABLE EVERYWHERE,  
JUST MAKE SURE THE SIZE MATCHES MY  
SPECIFIED DIMENSIONS.



# DRYER Installation



LET'S ASSEMBLE THE SUPPORT FOR AMS OR HYDRA.  
TO AVOID MIXING THE PARTS, I'VE LABELED THEM.

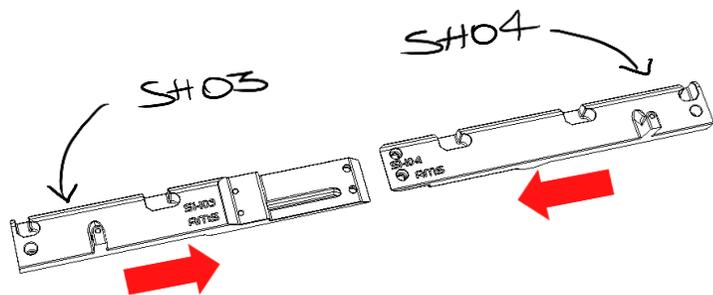
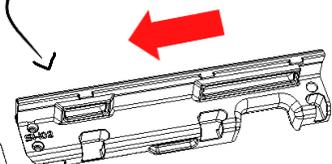
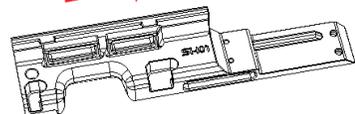
## REQUIRED HARDWARE

SCREWS 8

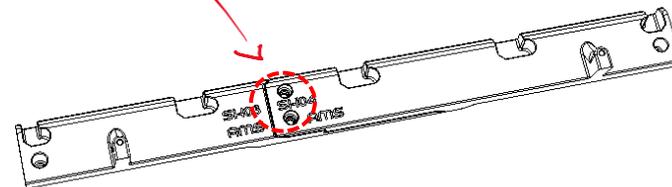
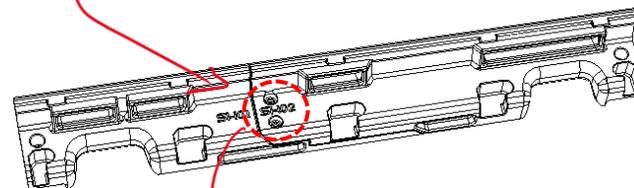
SH01

SH02

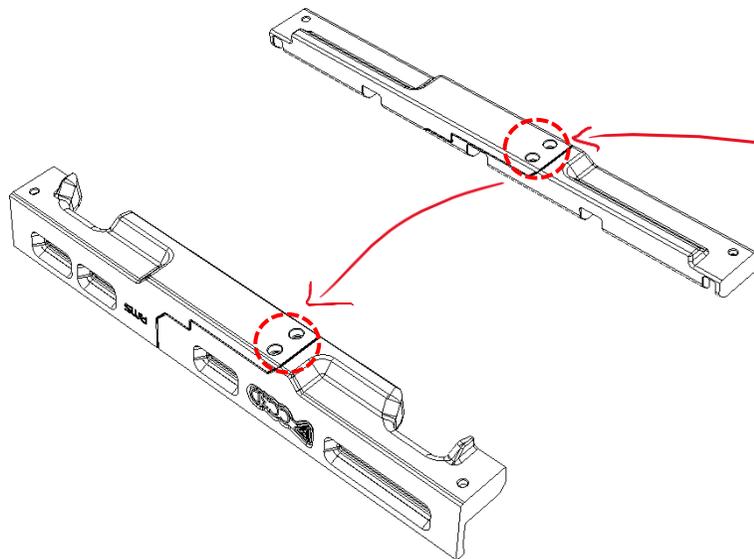
STEP 1 - ATTACH AND ALIGN THE PARTS .



STEP 2 - USE TWO SCREWS TO SECURE EACH PARTS .



STEP 3 - TURN THE ASSEMBLY OVER  
ADD TWO MORE SCREWS .



# DRYER Installation



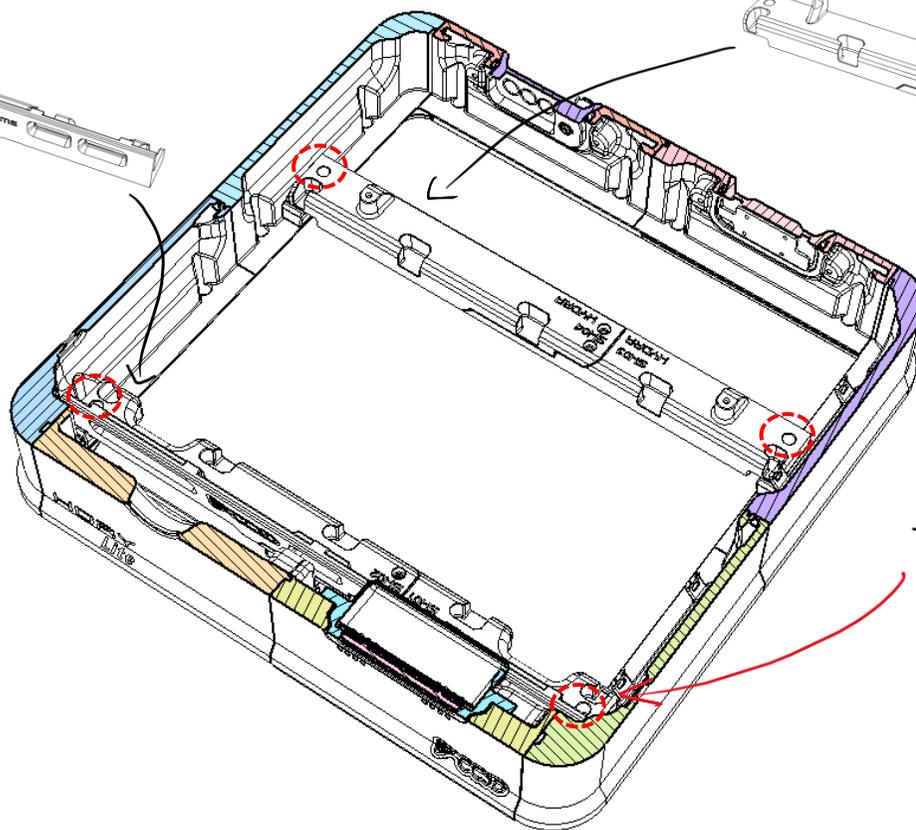
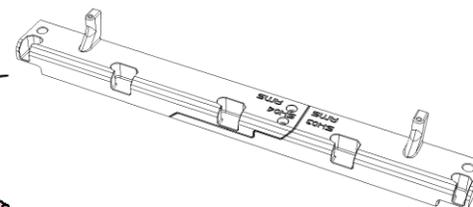
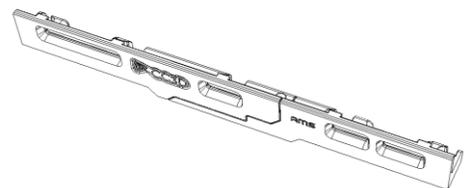
## REQUIRED HARDWARE

SCREWS 4

POSITIONING THE SUPPORTS INSIDE THE HDryLite.

THIS GOES TO THE FRONT

THIS GOES TO THE BACK.



YOU'LL FIND OUT HOLES AT THE END OF THE BARS.

INSERT A SCREW INTO EACH HOLE AND FASTEN THE BAR TO THE STRUCTURE.

# DRYER Installation

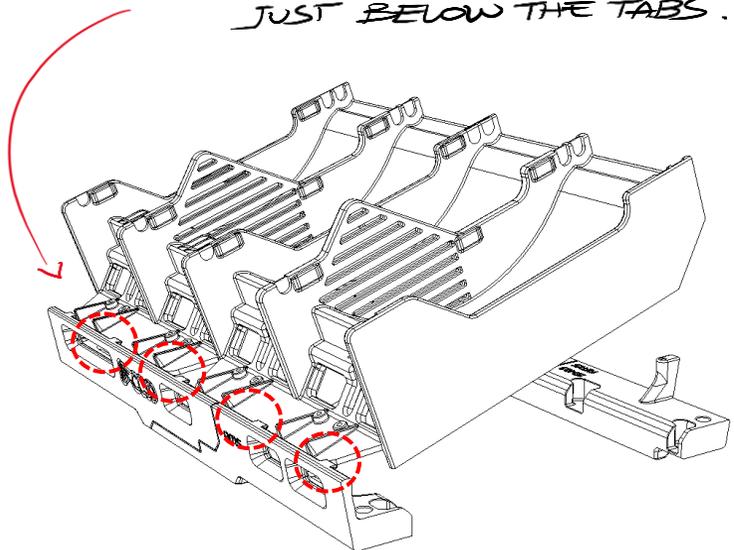


REQUIRED HARDWARE

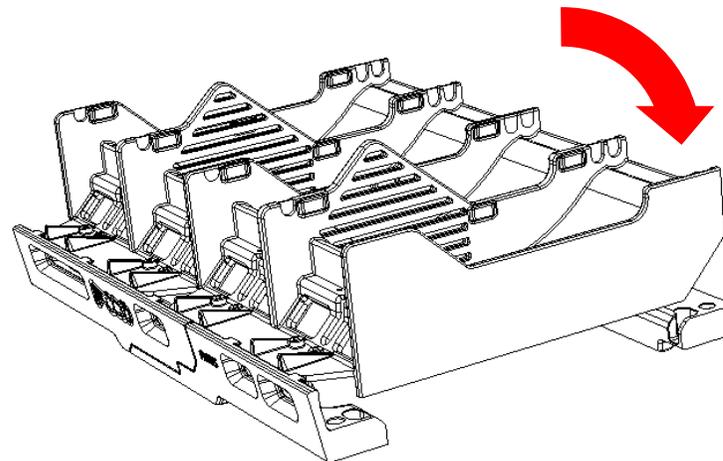
SCREWS 2

INSTALLING AMS OR HYDRA

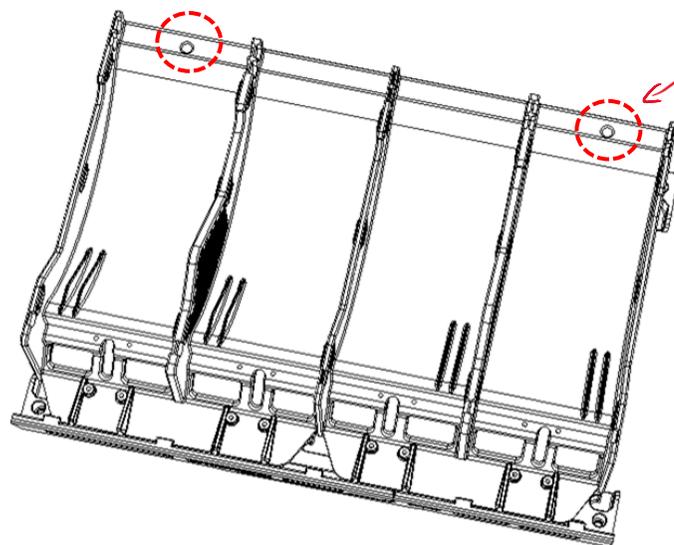
STEP 1 - PLACE THE AMS'S FRONT ON THE FRONT BAR,  
JUST BELOW THE TABS.



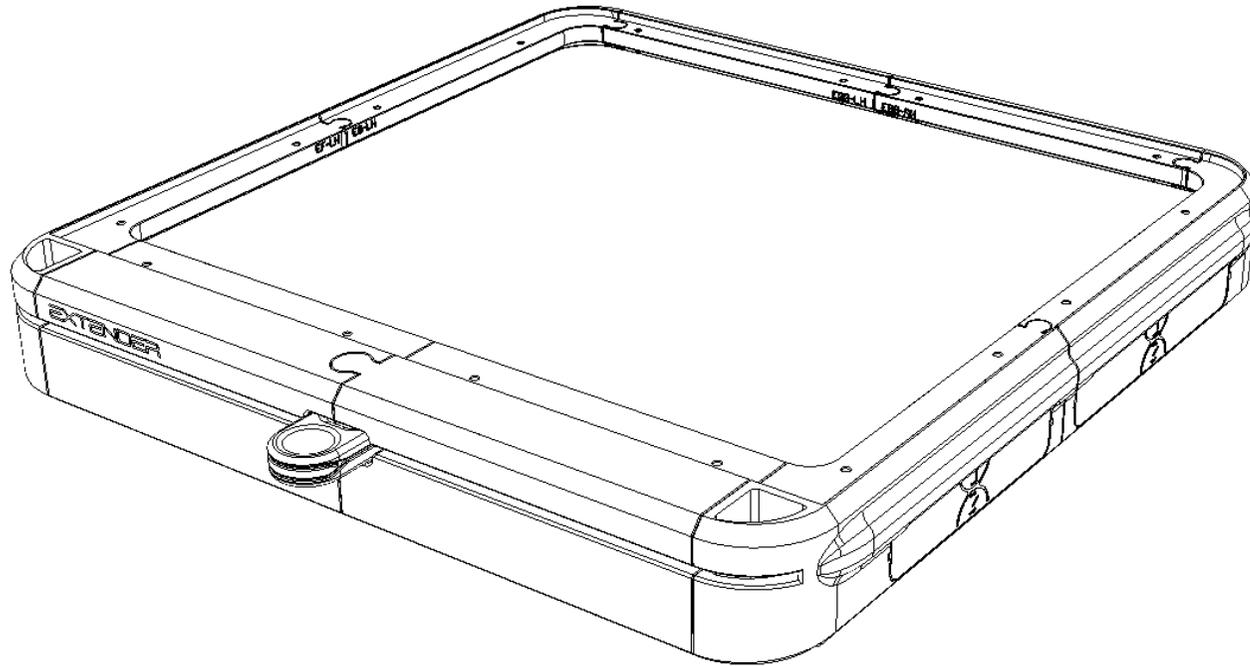
STEP 2 - REST THE REAR SECTION ON  
THE REAR SUPPORT



STEP 3 - USE THE SCREWS PROVIDED  
WITH THE AMS, TIGHTEN THEM  
SECURELY, AND YOU ARE ALL SET.



NOW LET'S BUILD THE EXTENDER.  
IT'S MOSTLY INTERLOCKING PIECES, BUT WE'LL NEED  
A FEW SCREWS HERE AS WELL.



# Extension Assembly

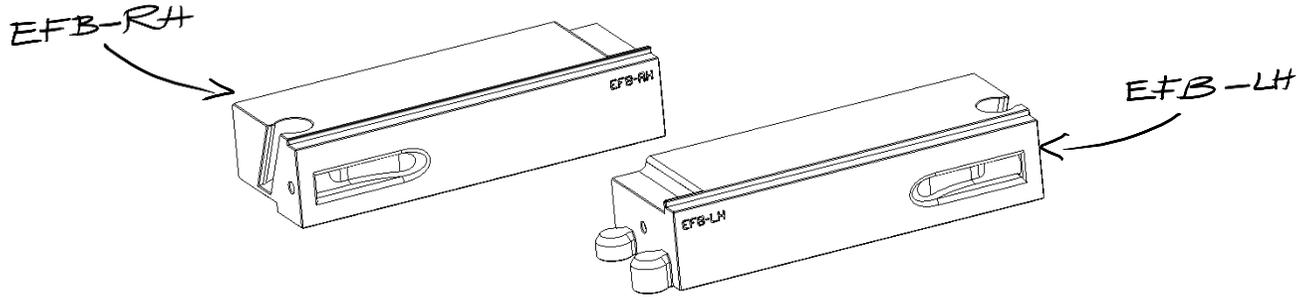


REQUIRED HARDWARE

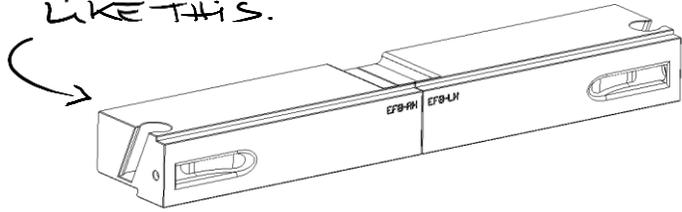
LET'S ASSEMBLE THE EXTENSION .

SCREWS 1

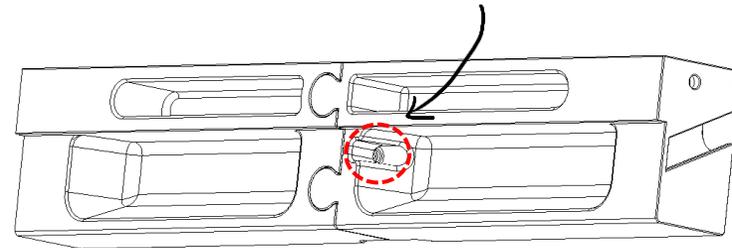
1 - ALIGN THE PINS AND CONNECT THE 2 PIECE



ONCE ASSEMBLED, IT SHOULD LOOK LIKE THIS.



2 - FLIP THE PIECE OVER AND SECURE IT WITH A SCREW IN THE HIGHLIGHTED HOLE.

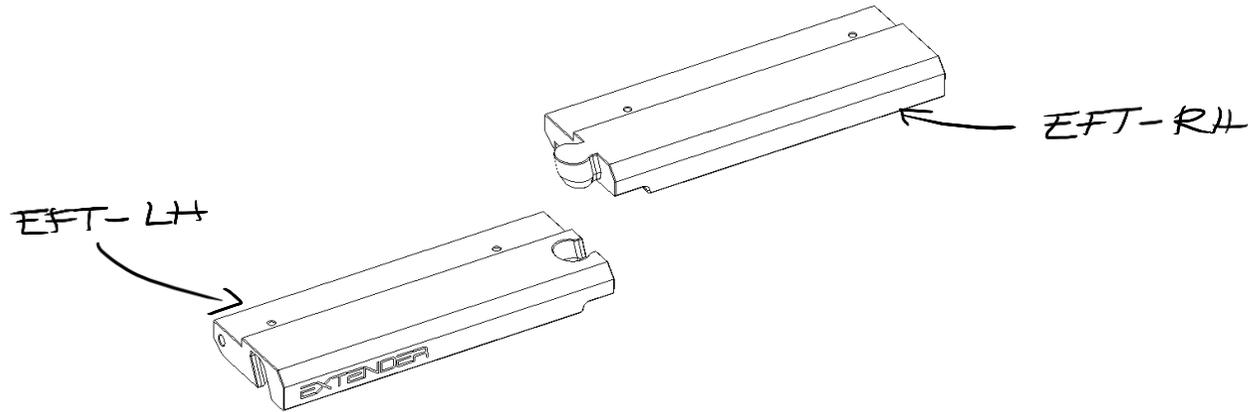


# Extension Assembly

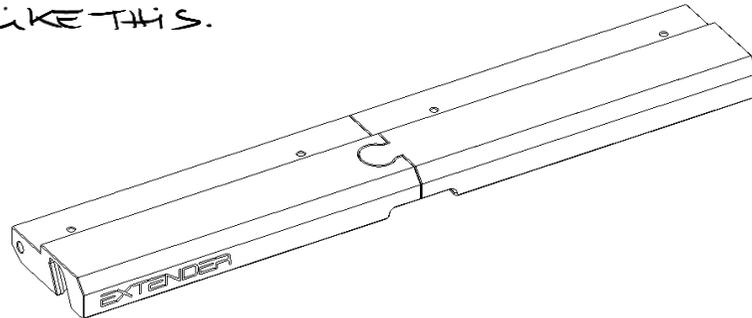


## REQUIRED HARDWARE

1 - ALIGN THE PINS AND CONNECT THE 2 PIECE



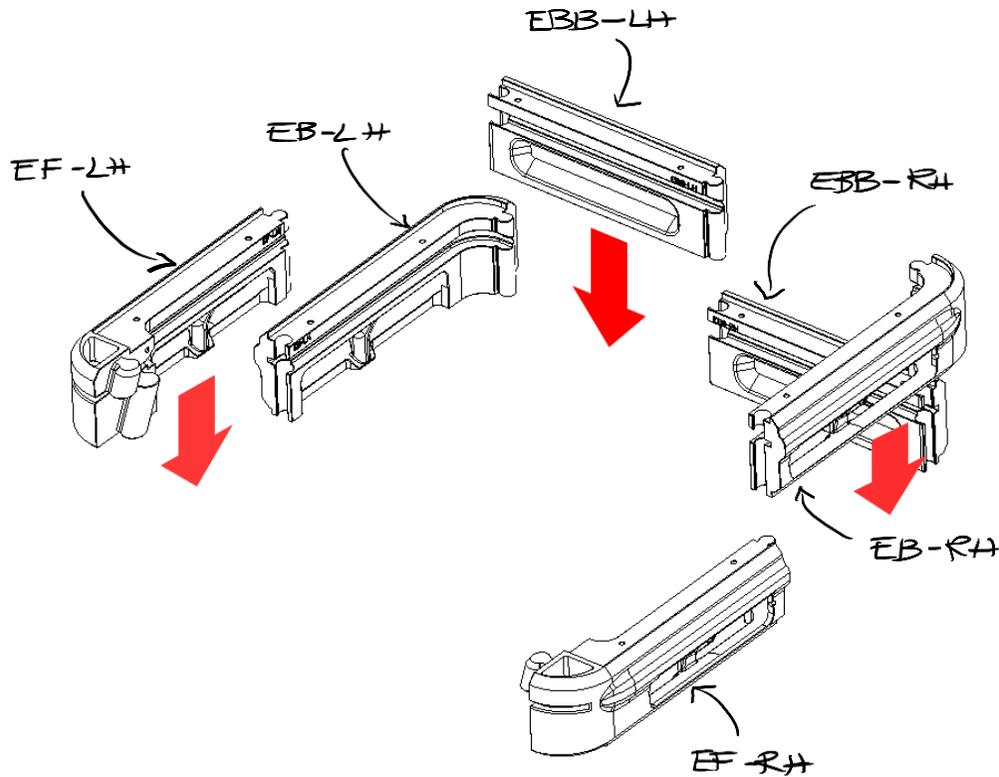
ONCE ASSAMBLLED, IT SHOUD LOOK LIKE THIS.



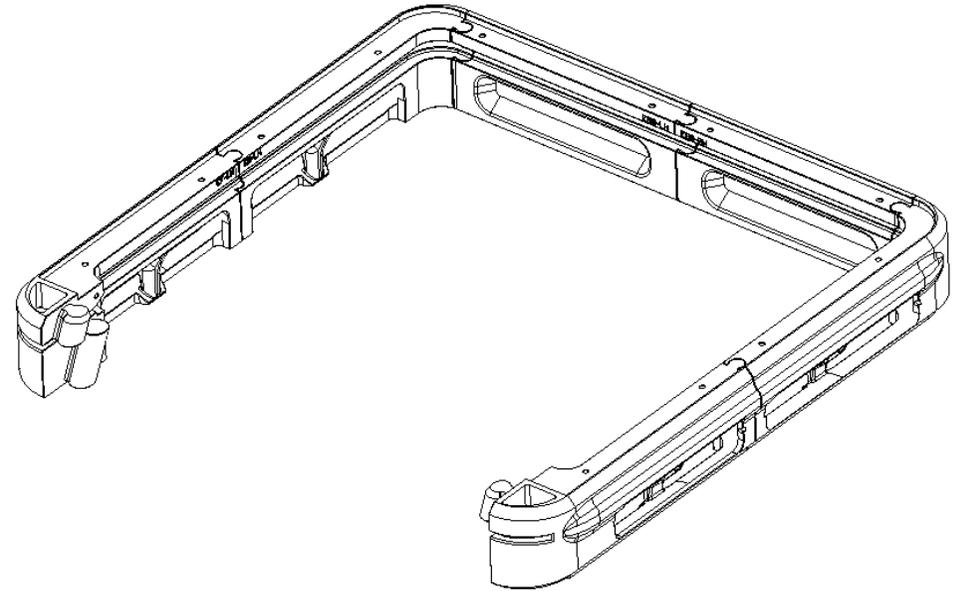
# Extension Assembly



ALL THE PIECES SNAP TOGETHER SECURELY,  
NO SCREW OR GUE NEEDED.



ONCE ASSAMBLIED, IT SHOULD LOOK LIKE THIS.

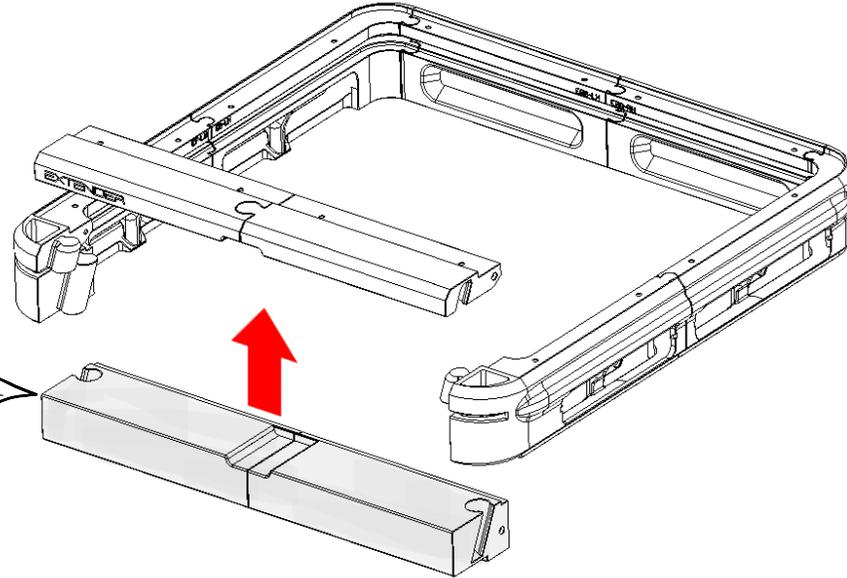


# Extension Assembly

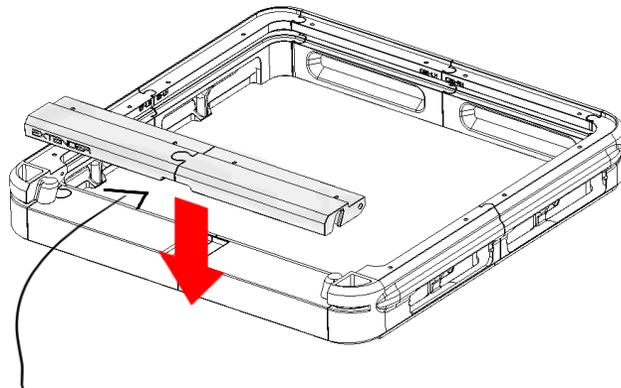
## REQUIRED HARDWARE

- SCREWS 8 ✓
- GASKET — X
- GLUE — X

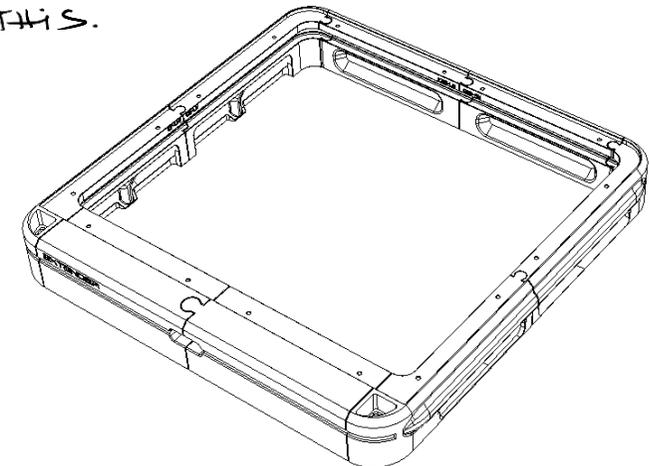
SNAP THE PIECE INTO PLACE  
BY ALIGNING IT AND SLIDING  
IT INTO THE PINS.



ONCE ASSEMBLED, IT SHOULD LOOK  
LIKE THIS.



SNAP THE PIECE INTO PLACE  
BY ALIGNING IT AND SLIDING  
IT INTO THE PINS.



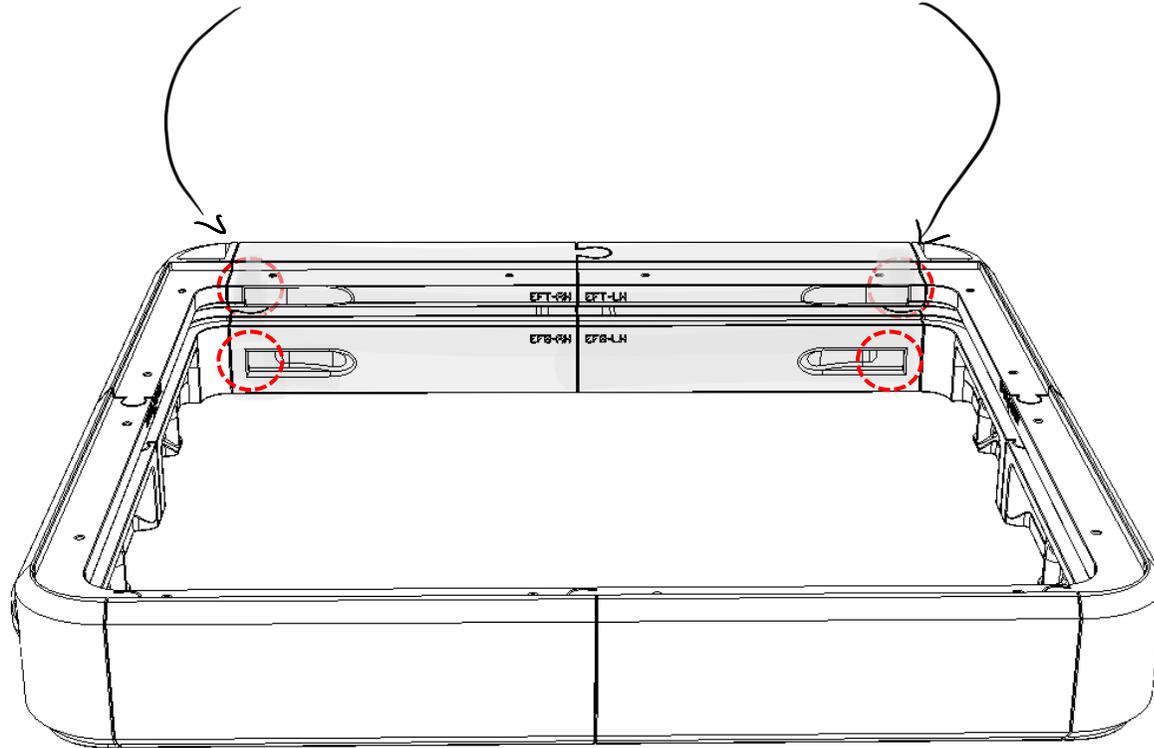
# Extension Assembly



## REQUIRED HARDWARE

SCREWS 4

ROTATE THE STRUCTURE AND SECURE THE FRONT SIDES BY INSERTING SCREWS INTO THE HIGHLIGHTED HOLES.

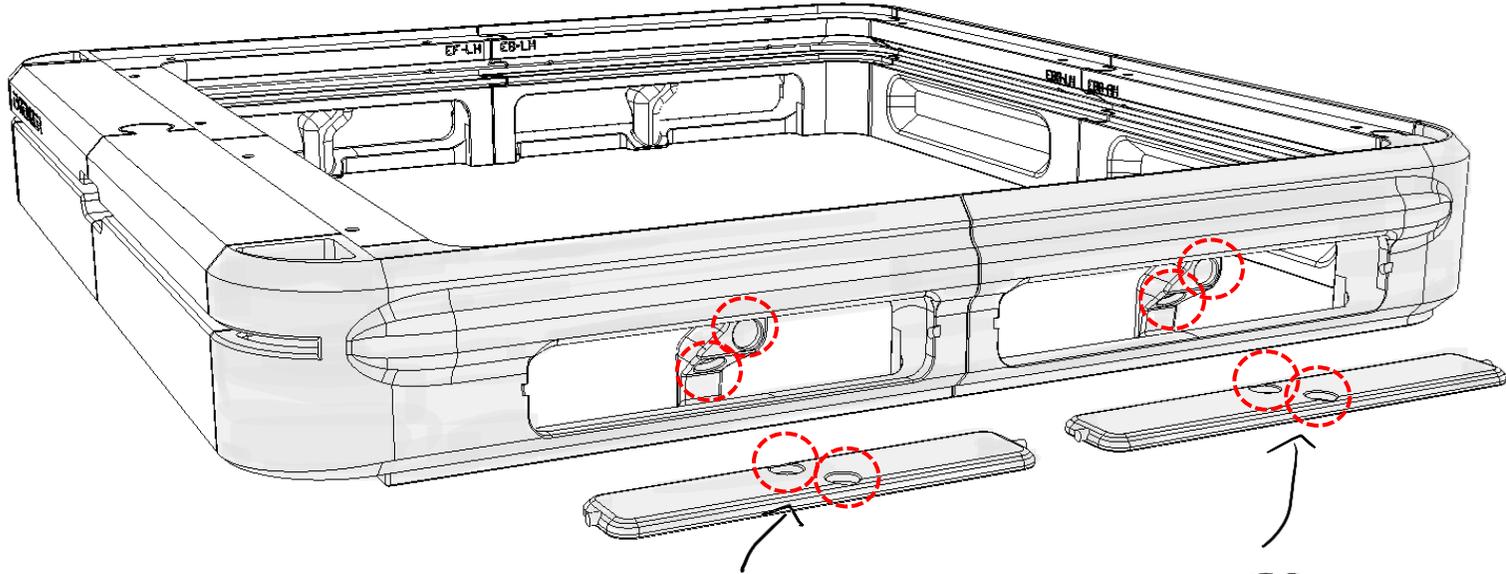


# Extension Assembly



REQUIRED HARDWARE  
MAGNETS 16  
GLUE

NOW IT'S TIME TO INSTALL THE VENTILATION DOORS.



ATTACH THE TO BOTH STRUCTURE AND DOORS.  
NOTE THAT DOORS ARE LABELED LEFT AND RIGHT.  
(I'VE HIGHLIGHTED THE MAGNET HOLES)

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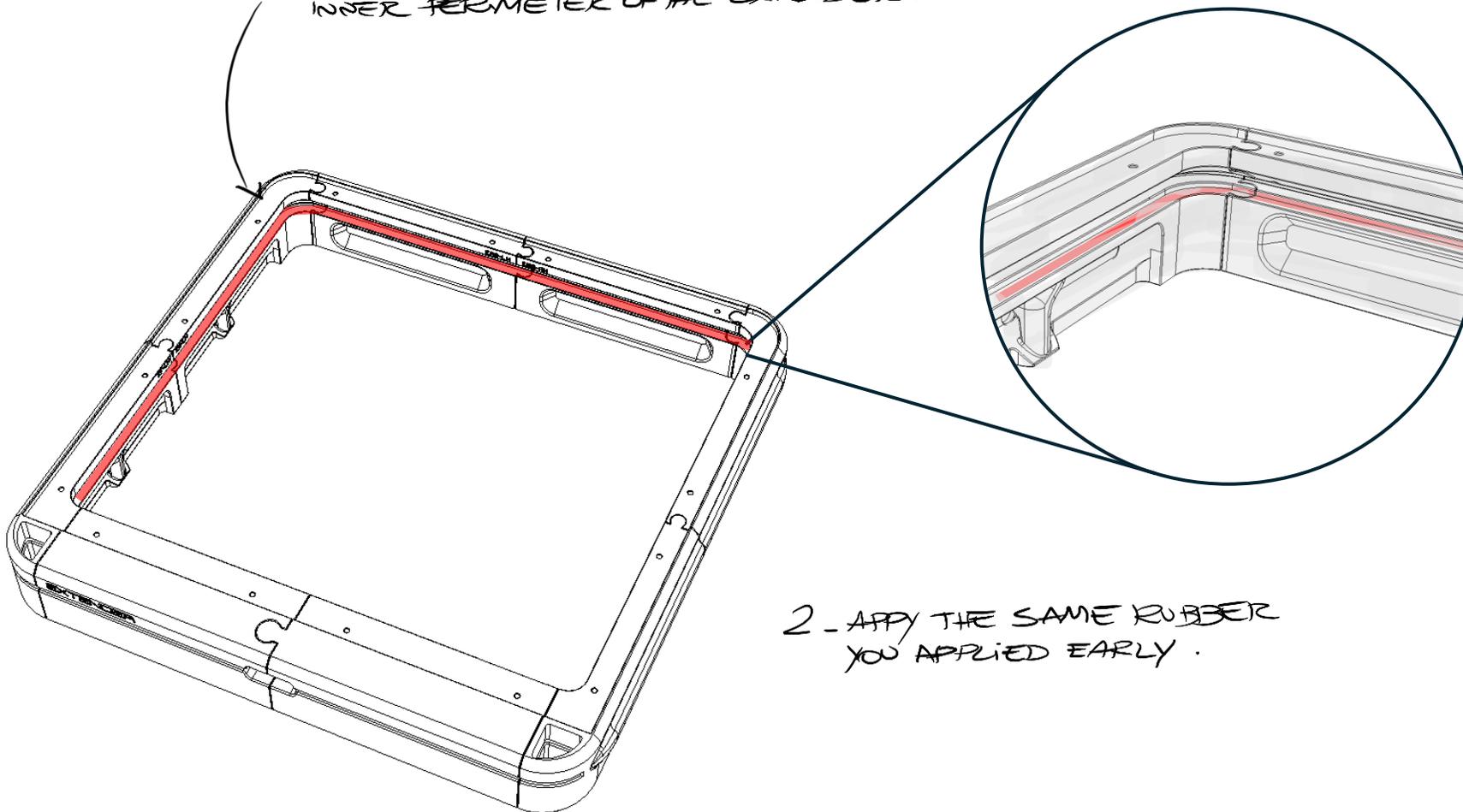
# Extension Assembly

REQUIRED HARDWARE

GASKET

INSTALL THE SEAL FOR THE GLASS.

1 - LOCATE THE GROOVE ALONG THE ENTIRE INNER PERIMETER OF THE EXTENDER.



2 - APPLY THE SAME RUBBER YOU APPLIED EARLY.

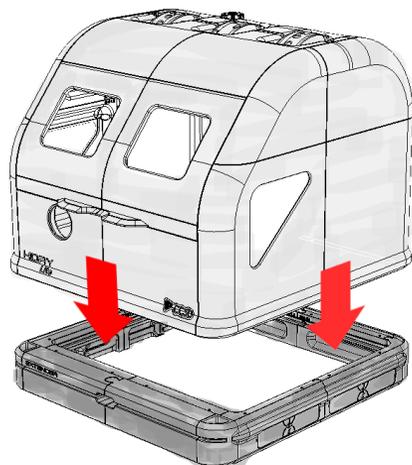
# Main BODY assembly

REQUIRED HARDWARE

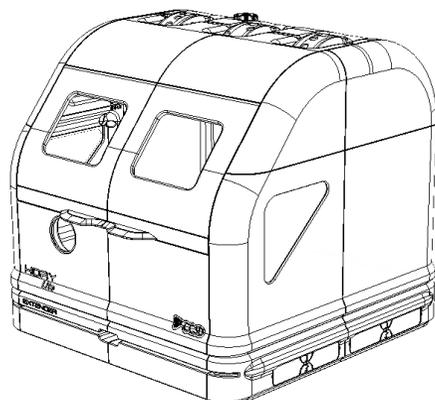
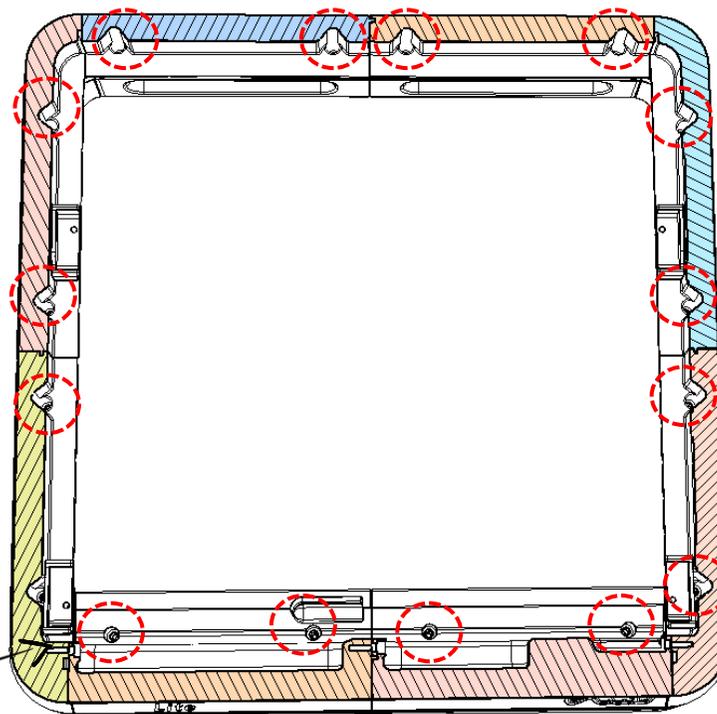
SCREWS 14

IT'S TIME FOR THE "MARRIAGE".

1. PLACE THE HDRY life ONTO THE EXTENDER .



IN THIS TOP-DOWN EXPLODED VIEW, I'VE HIGHLIGHTED THE SCREW HOLES NEEDED TO JOIN THE TWO COMPONENTS



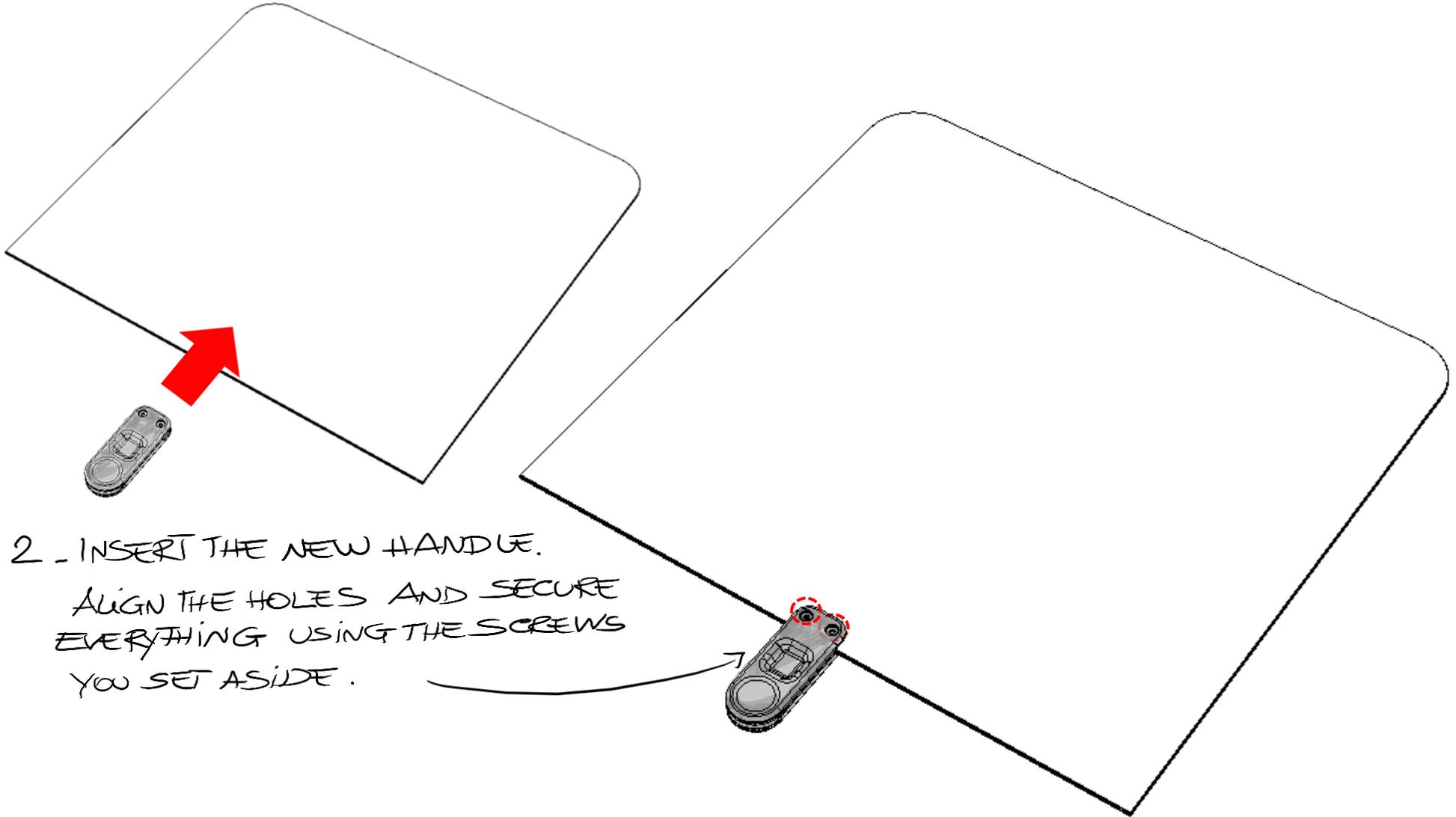
2 - SIMPLY INSERT THE SCREWS AND SECURE EVERYTHING IN PLACE.

# GLASS assembly

REQUIRED HARDWARE

INSTALLING NEW HANDLE ON THE PRINTER TOP GLASS .

1\_ REMOVE THE OLD HANDLE, TAKING CARE NOT TO LOSE THE RUBBER SPACER, AND KEEP THE SCREWS HANDLY .



2\_ INSERT THE NEW HANDLE.

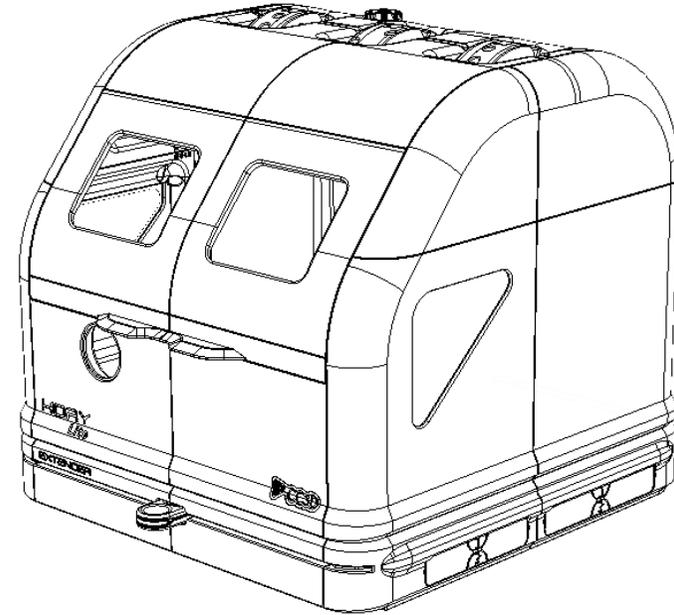
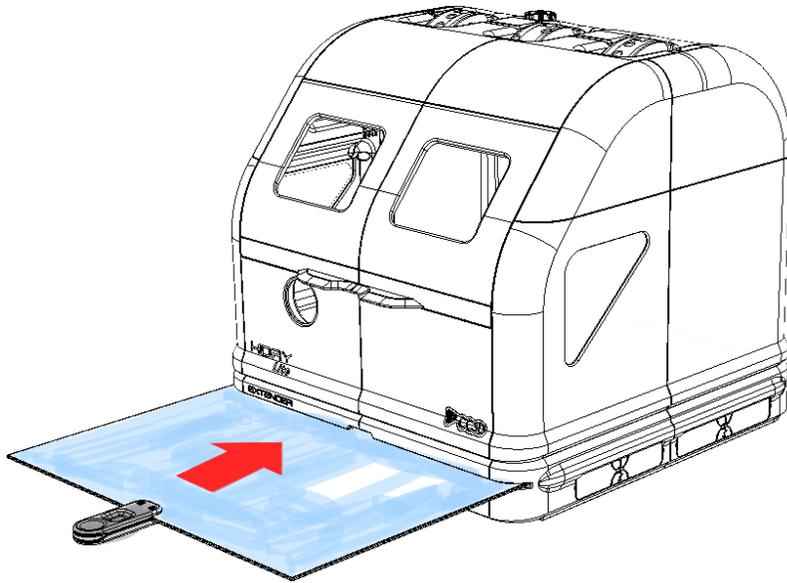
ALIGN THE HOLES AND SECURE EVERYTHING USING THE SCREWS YOU SET ASIDE .

# Main BODY assembly

REQUIRED HARDWARE

FINAL STEP - INSERT THE GLASS.

SLIDE THE GLASS INTO PLACE  
PUSHING IT ALL THE WAY DOWN.





*THANKS FOR STICKING WITH ME THROUGH THIS ASSEMBLY GUIDE!*

*IT TOOK ME HOURS TO PUT THIS GUIDE TOGETHER, AND I TRULY HOPE IT'S BEEN CLEAR AND EASY TO FOLLOW.*

*IF THERE'S ANYTHING THAT WASN'T SUPER CLEAR OR IF YOU FEEL LIKE SOMETHING'S MISSING, DON'T HESITATE TO REACH OUT.*

*I'M ALWAYS HERE TO HELP AND PROVIDE ANY SUPPORT OR CLARIFICATION YOU NEED.*

*ENJOY YOUR NEW FEATURE!*

*CIAO!!!*



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