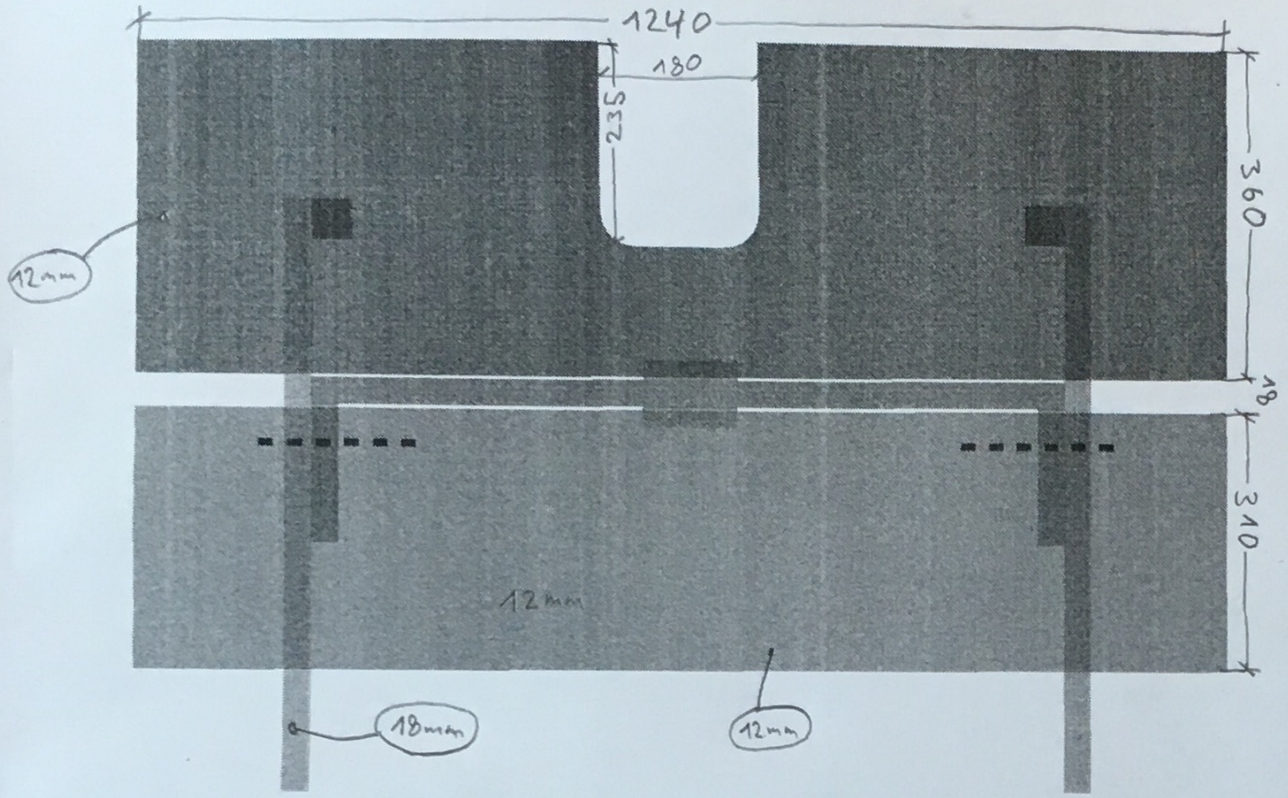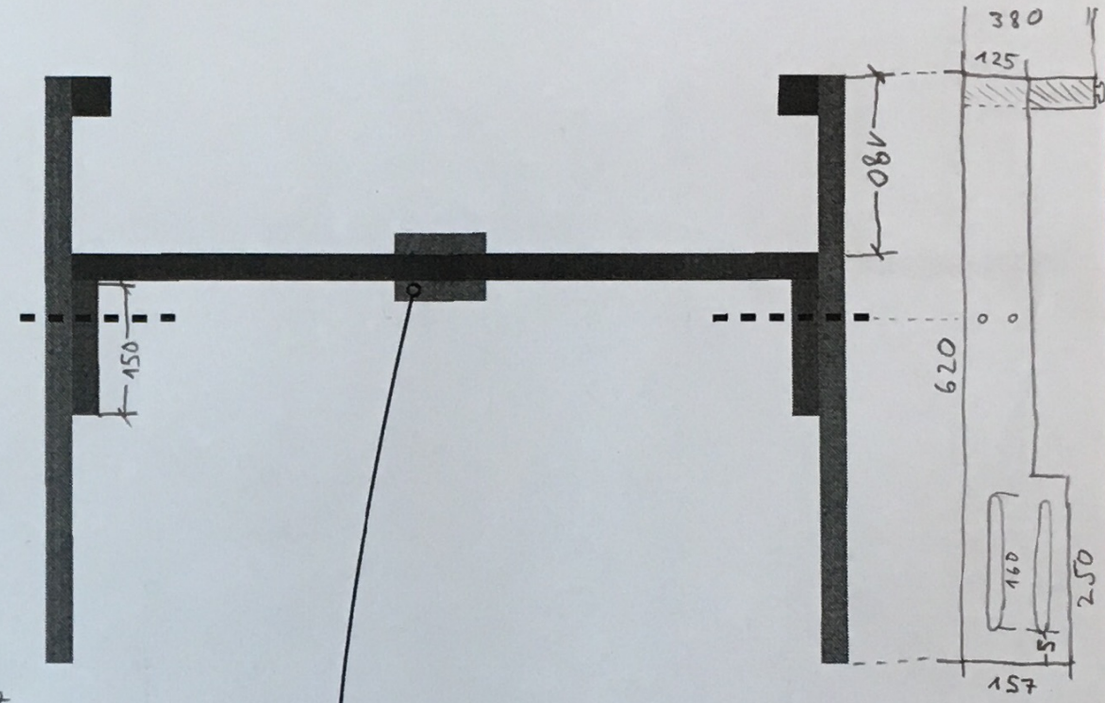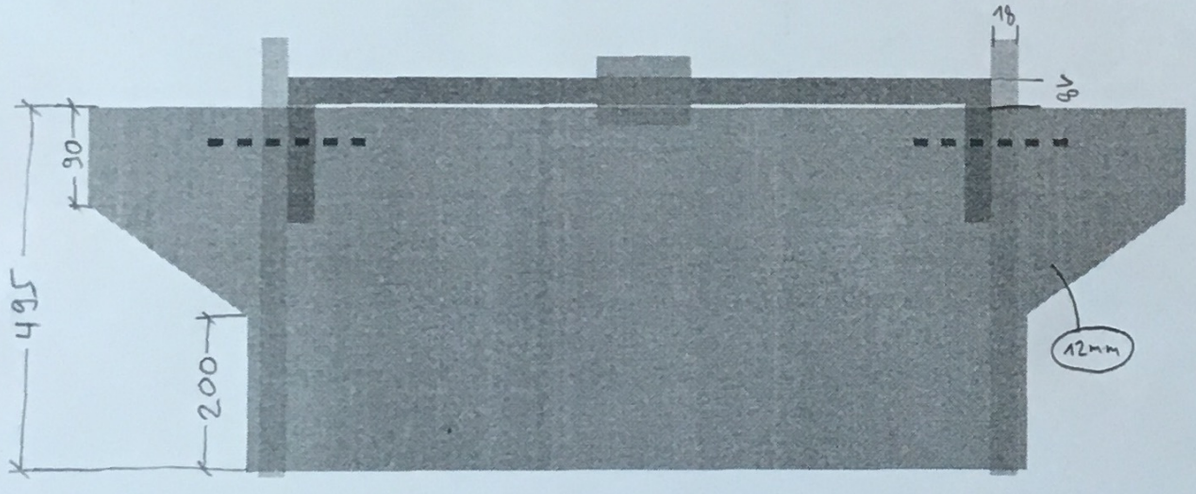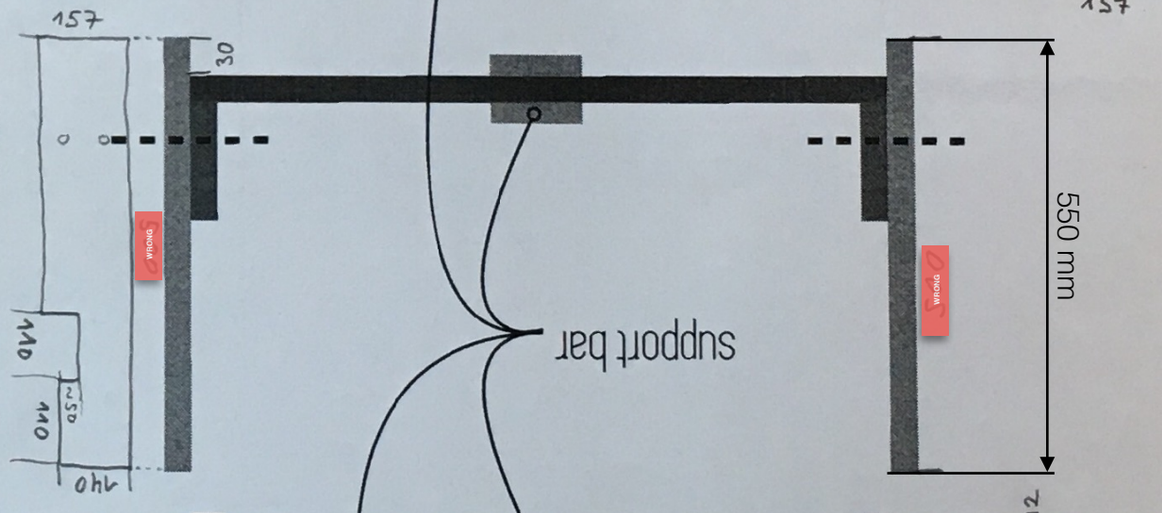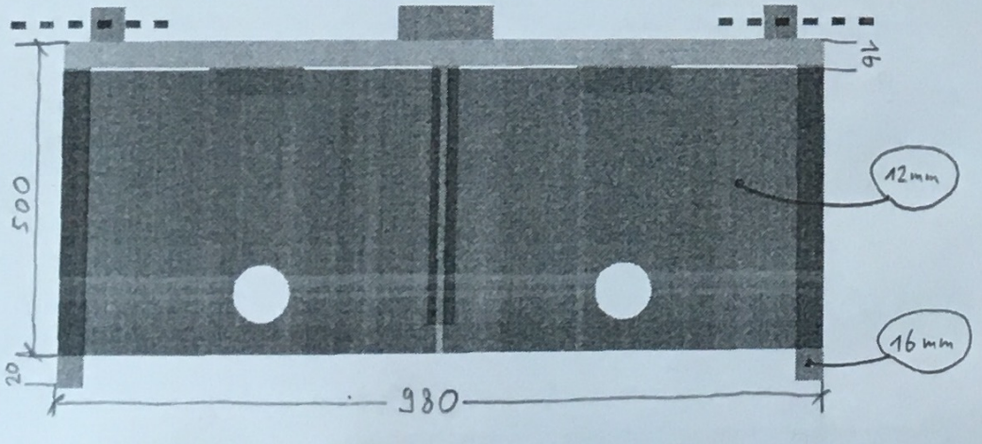All units in metric mm !