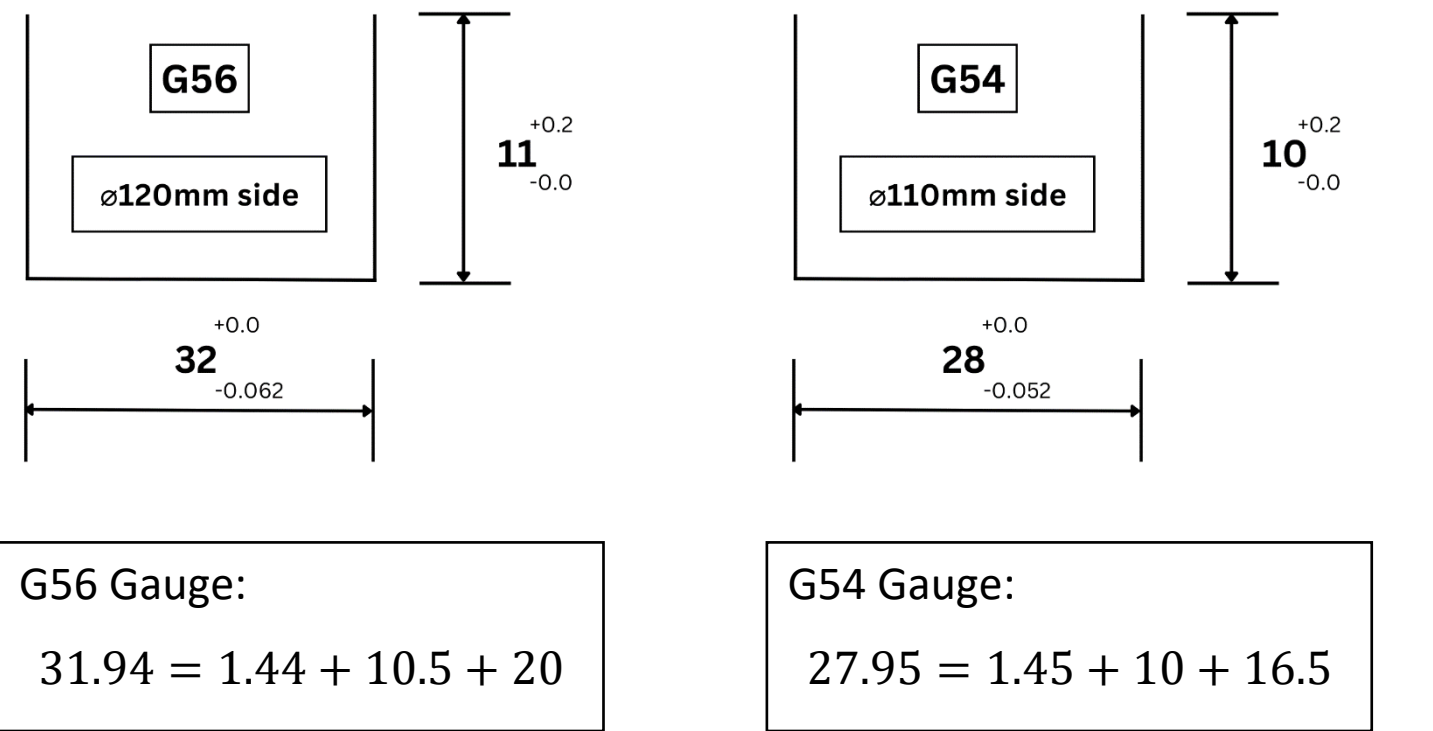


# FLENDER DRAWING F2E01473648A

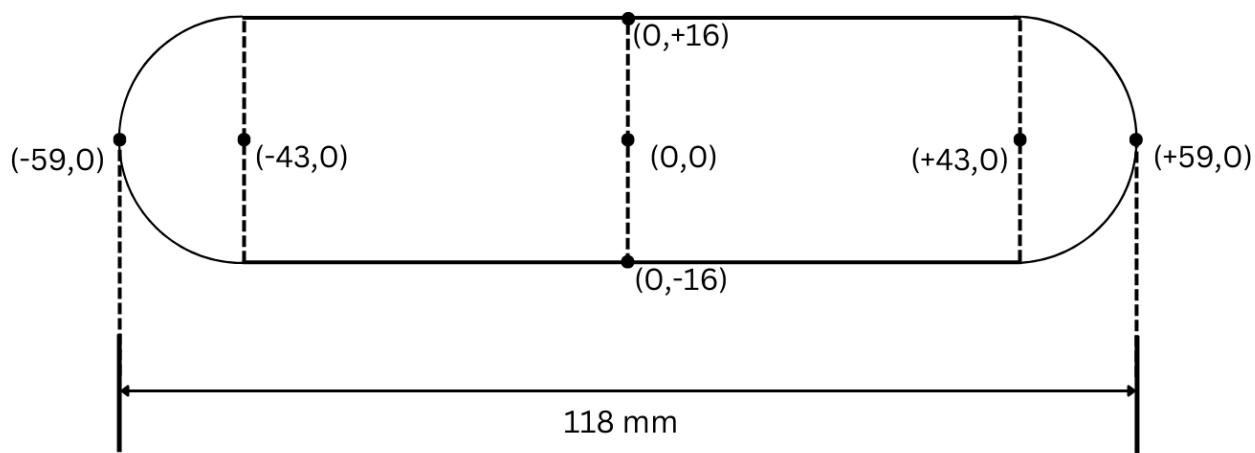
Minimum V-Block Gap for  $\varnothing 120\text{mm}$  diameter = 40 mm



## TOLERANCE

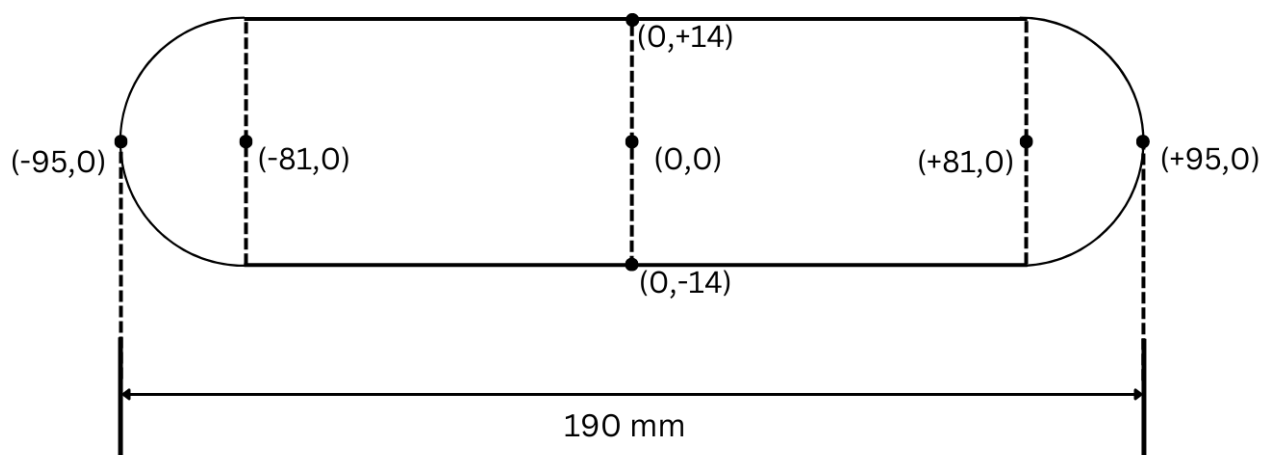
Side	120mm - G56		110mm - G54	
	Actual	Tolerance	Actual	Tolerance
Width	32	+0 / -0.062	28	+0 / -0.052
Depth	11	+0.2 / -0	10	+0.2 / -0
Length	118		190	
Symmetry		0.055		0.055
Reference	10		16	

**G56:** Ø120mm side – CLOSED SLOT (Left side)



Drawing Reference	10 mm
Centre Distance from reference Collar	69 mm
Centre Distance from reference slot Edge	59 mm

**G54:** Ø110mm side – CLOSED SLOT (Right side)



Drawing Reference	16 mm
Centre Distance from reference Collar	111 mm
Centre Distance from reference slot Edge	95 mm

# OFFSETS

NUMBER	TOOL	SIDE	H LOCATION	D LOCATION
13	Marking Pencil	G56	H90	Not Required for Checking
		G54	H91	
14	ø26.5mm Insert DRILL	G56	H92	Not Required for Drilling
		G54	H93	
15	ø25mm CUTTER (16mm Insert)	G56	H94	Not Required for Slotting
		G54	H95	
16	ø25mm CUTTER (9mm Insert)	G56	H96	D96 = 13.0
		G54	H97	D97 = 13.0
17	ø16mm SC ENDMILL	G56	H98	D98 = 8.4
		G54	H100	D100 = 8.4
		G56	Not required for Finishing	<b>D101</b> = 8.2
		G54		<b>D102</b> = 8.2

# PROGRAMMING

O6481	Checking
<p>* Check if Pencil Marking Tool is stopping at the edge of the Reference Collar. If not, please stop program and re-measure centre distance (x axis).</p> <p>Program will stop before every tool dip to 1mm. Measure Z centring here if needed. If any tool touches the job body, H value (height compensation) is deviating by more than 1mm. Please rectify the tool height and try again.</p>	

O6482	Roughing
<p>Please <b>MEASURE SYMMETRY</b> after completion. If symmetry deviation is <b>30-micron</b> or more, shift Y-axis as required.</p> <p>Only reduce tool radius after width measurement. Radius reduction will be according to stock material remaining.</p>	

O6483		Finishing	
G56	H98	D101	R = 8.2
G54	H100	D102	R = 8.2
Please <b>CHECK SLIP GAUGE AFTER G56</b> side completes. In case of deviation, stop program and report. Slip gauge must go fully inside the keyway to pass. Reduce radius accordingly.			

O6484	Depth
<p>Depth slotting for middle bar with 16mm Diameter SC End-Mill.</p>	

# CHECKLIST

O6482		Roughing		
Operation	Side	H Offset	D offset	Radius
Drilling	G56	H92	Not Required	
	G54	H93		
Slotting	G56	H94		
	G54	H95		
Semi roughing	G56	H96	<b>O6488</b>	
	G54	H97	<b>O6487</b>	
Semi finishing	G56	H98	D98	R = 8.4
	G54	H100	D100	R = 8.4

O6483		Finishing		
Operation	Side	H Offset	D offset	Radius
Wall finish	G56	H98	<b>D101</b>	R = 8.2
	G54	H100	<b>D102</b>	R = 8.2

O6484		Depth		
Operation	Side	H Offset	D offset	Radius
Depth finish	G56	H98	Not Required	
	G54	H100		

O6487		Semi Roughing		
Operation	Side	H Offset	D offset	Radius
Sub-program	<b>G54</b>		D97	R = 13.0

O6488		Semi Roughing		
Operation	Side	H Offset	D offset	Radius
Sub-program	<b>G56</b>		D96	R = 13.0