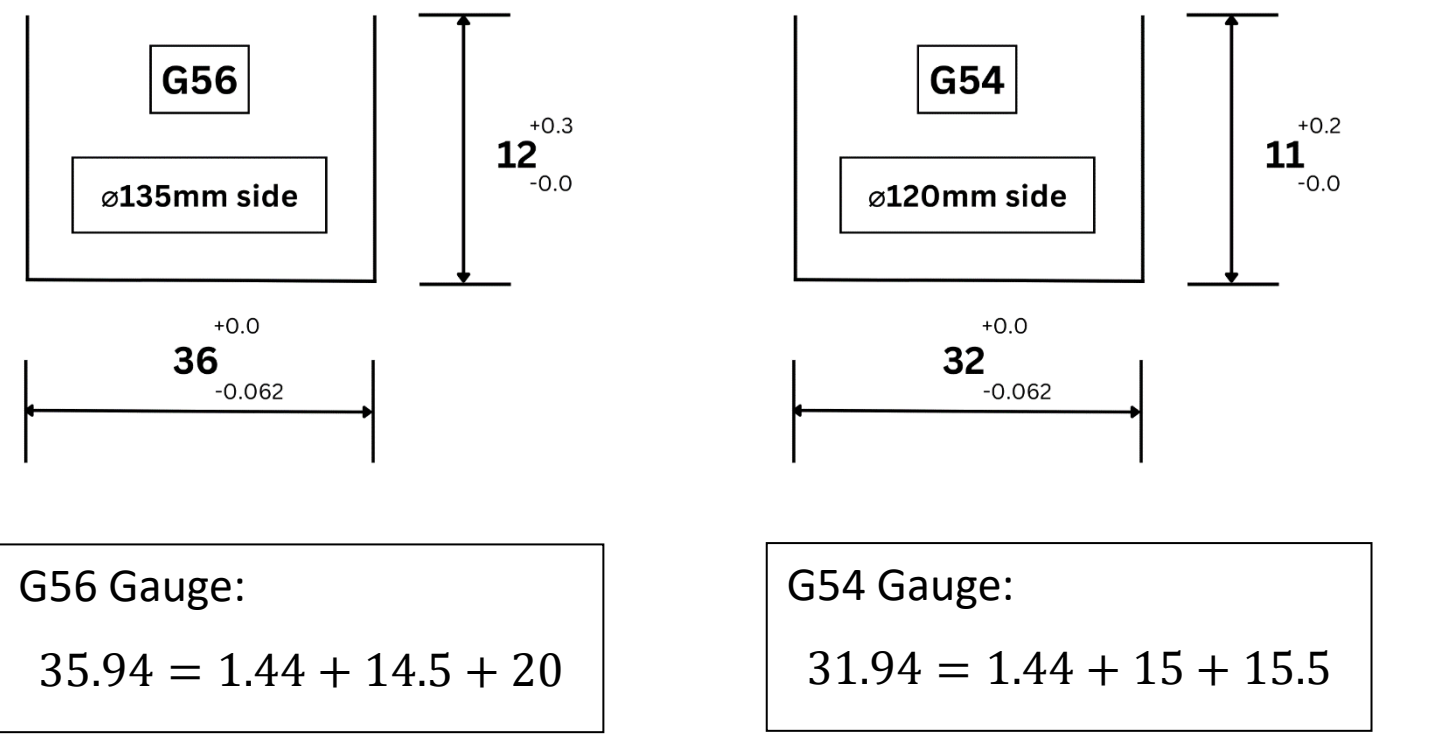
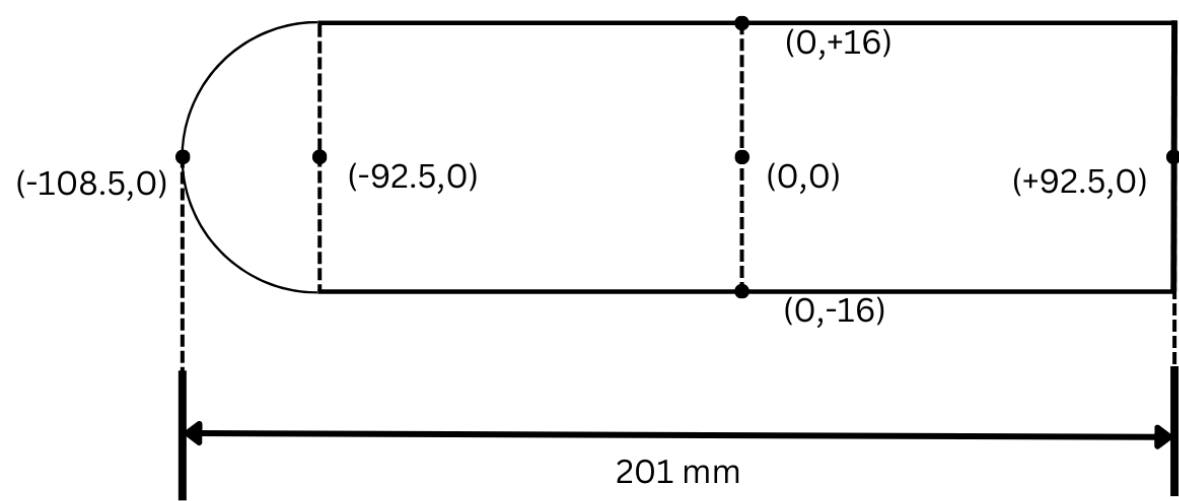


FLENDER DRAWING 5876672

Minimum V-Block Gap for $\varnothing 130\text{mm}$ diameter = 180 mm

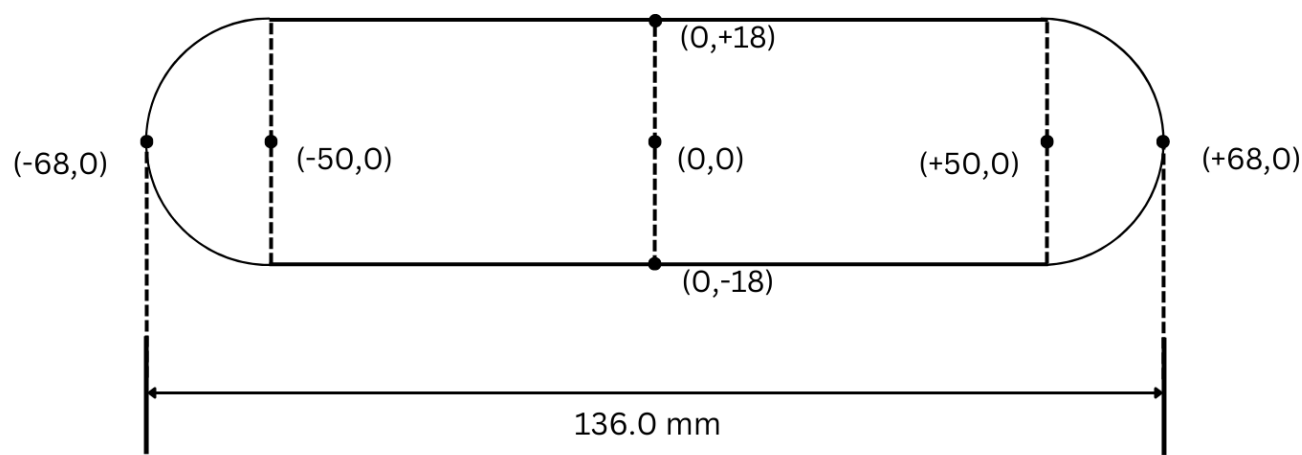


G54: $\varnothing 120\text{mm}$ side – OPEN SLOT (Right side)



- ⇒ Drawing Reference = 9 mm
- ⇒ Centre distance from collar = 117.5 mm

G56: Ø135mm side – CLOSED SLOT (Left side)



- ⇒ Drawing Reference = 19 mm
- ⇒ Centre distance from collar = 49 mm

OFFSETS

NUMBER	TOOL	SIDE	H LOCATION	D LOCATION
14	Ø25.6mm Insert DRILL	G56	H220	
		G54	H221	
15	Ø25mm Insert CUTTER R = 13.0	G56	H222	D222
		G54	H223	D223
16	Ø16mm SC CUTTER R = 8.4	G56	H224	D224
		G54	H225	D225
		G56		D226
		G54		D227

PROGRAMMING

O6721 – Checking

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.

O6722 – Roughing

Please **MEASURE SYMMETRY** after completion. If symmetry deviation is **40-micron** or more, shift Y-axis as required.

Only reduce tool radius after width measurement. Radius reduction will be according to stock material remaining.

O6723 – Finishing

Please **CHECK SLIP GAUGE AFTER G56** side completes. In case of deviation, stop program and report. Do not continue G54 side before checking.

Slip gauge must go fully inside the keyway to pass. Reduce radius accordingly.

O6724 – Depth finishing

This program is only for finishing cutter with less than 20mm Diameter. It is not required for 20mm Diameter and above.
