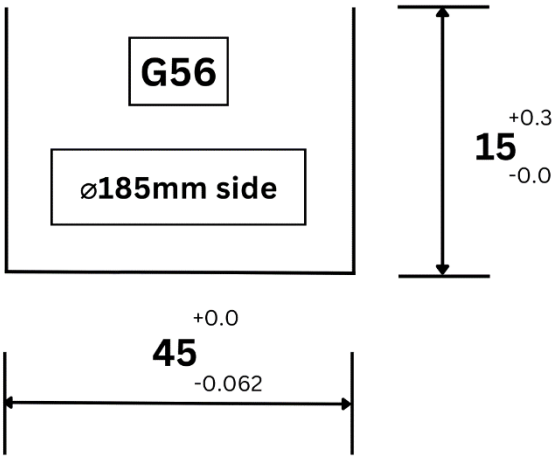
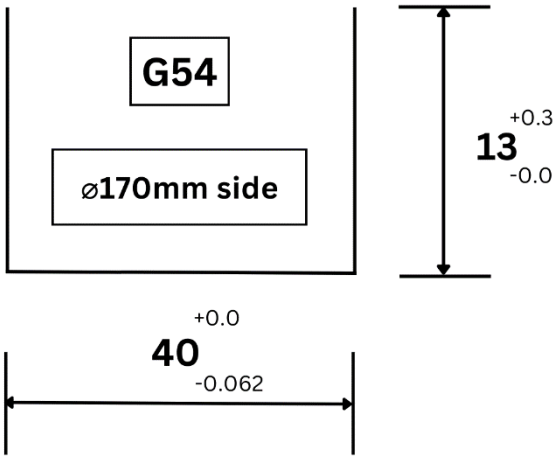
FLENDER DRAWING 5876660

Minimum V-Block Gap for ⌀180mm diameter = 260 mm





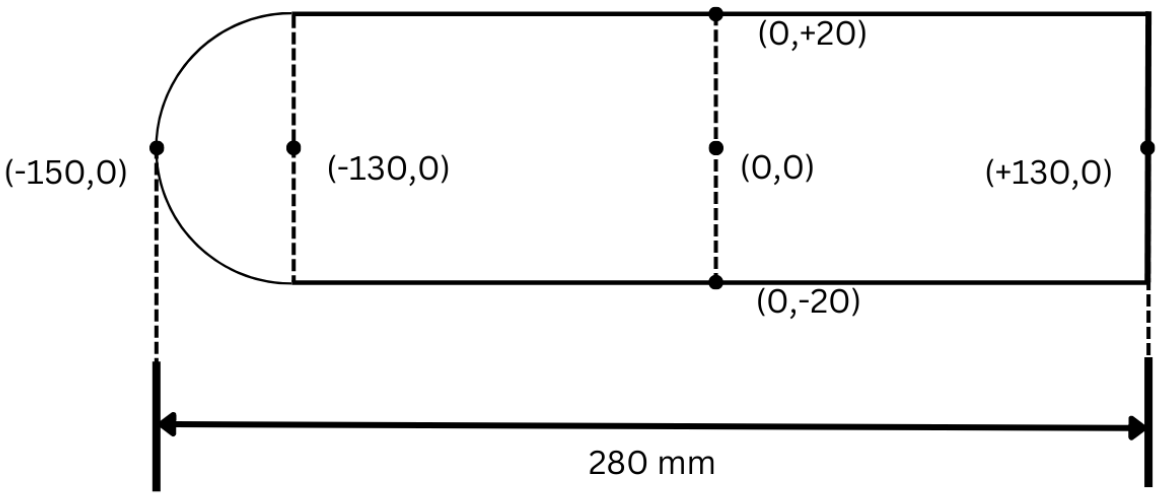
G56 Gauge:

$$44.94 = 1.44 + 20 + 23.5$$

G54 Gauge:

$$39.94 = 1.44 + 18 + 20.5$$

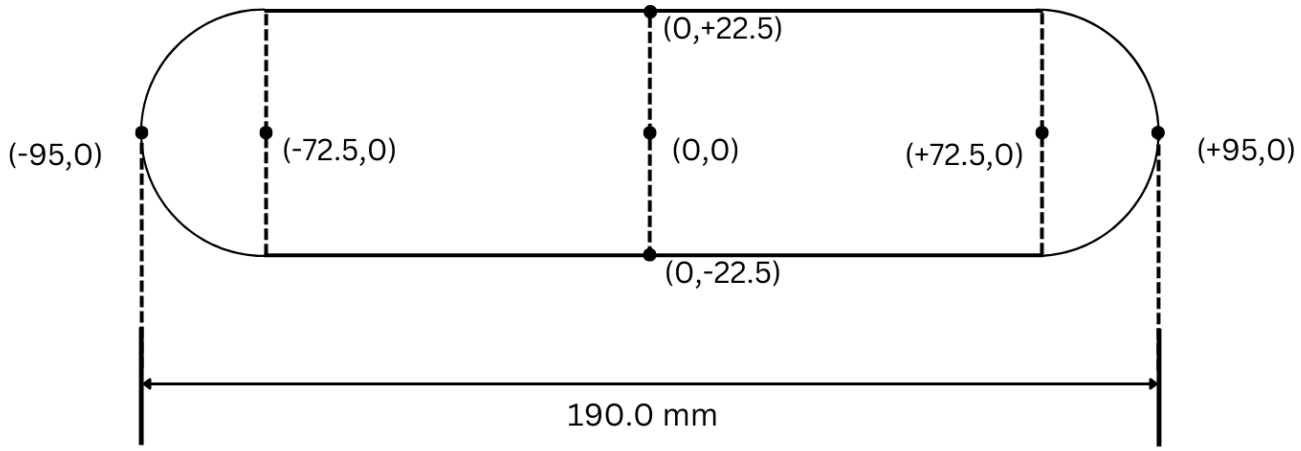
G54: ⌀170mm side – OPEN SLOT (Right side)



⇒ Drawing Reference = 20 mm

⇒ Centre distance from left collar = 170 mm

G56: ⌀185mm side – CLOSED SLOT (Left side)



⇒ Drawing Reference = 23.5 mm

⇒ Centre distance from right collar = 71.5 mm

OFFSETS

NUMBER	TOOL	SIDE	H LOCATION	D LOCATION
14	⌀26.5mm Insert DRILL	G56	H250	Not Required for Drilling
		G54	H251	
15	⌀25mm CUTTER (16mm Insert)	G56	H252	Not Required for Slotting
		G54	H253	
16	⌀25mm CUTTER (9mm Insert)	G56	H254	D254 = 13.0
		G54	H255	D255 = 13.0
17	⌀16mm SC ENDMILL	G56	H256	D256 = 8.4
		G54	H257	D257 = 8.4
		G56	Not Required for Finishing	**D258** = 8.2
		G54		**D259** = 8.2

PROGRAMMING

O6601	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.	

O6602	Roughing
Please **MEASURE SYMMETRY** after completion. If symmetry deviation is **30-micron** or more, shift Y-axis as required. Only reduce tool radius after width measurement. Radius reduction will be according to stock material remaining.	

O6603		Finishing	
G56	H246	**D248**	R = 8.2
G54	H247	**D249**	R = 8.2
Please **CHECK SLIP GAUGE AFTER G56** side completes. In case of deviation, stop program and report. Slip gauge must go fully inside the keyway to pass. Reduce radius accordingly.			

TOLERANCE

Side	185mm – G56		170mm - G54	
	Actual	Tolerance	Actual	Tolerance
Width	45	+0 / -0.062	40	+0 / -0.062
Depth	15	+0.3 / -0	13	+0.3 / -0
Length	190		280	
Symmetry		0.070		0.083
Reference	23.5		20	