FLENDER DRAWING **5134734**
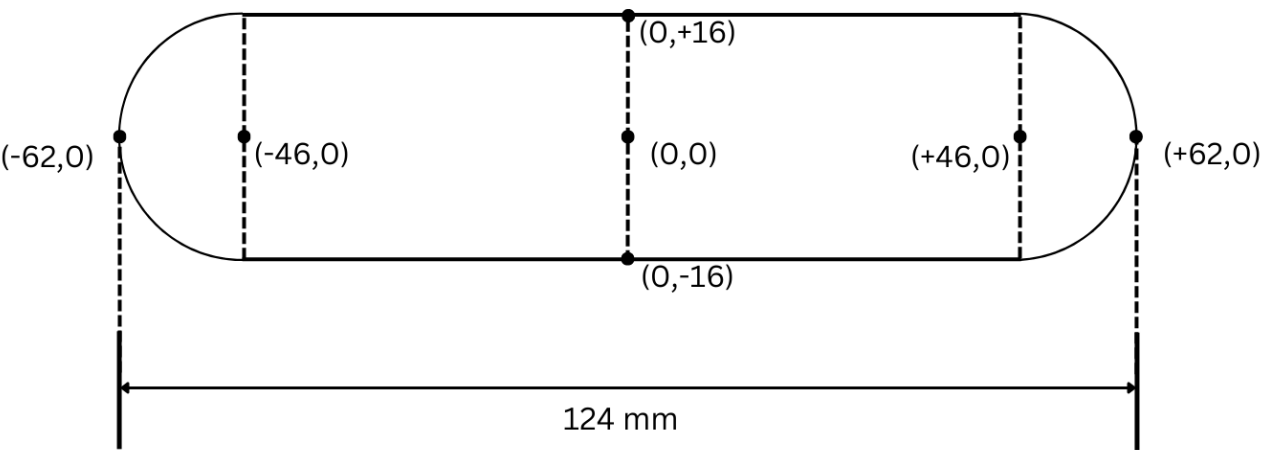
Minimum V-Block Gap for $\varnothing$120mm diameter = 185 mm

G56

$\varnothing$**125mm side**

$11^{+0.2}_{-0.0}$

$32^{+0.0}_{-0.062}$

G54

$\varnothing$**110mm side**

$10^{+0.2}_{-0.0}$

$28^{+0.0}_{-0.052}$

G56 Gauge:

$$31.94 = 1.44 + 10.5 + 20$$

G54 Gauge:

$$27.95 = 1.45 + 10 + 16.5$$
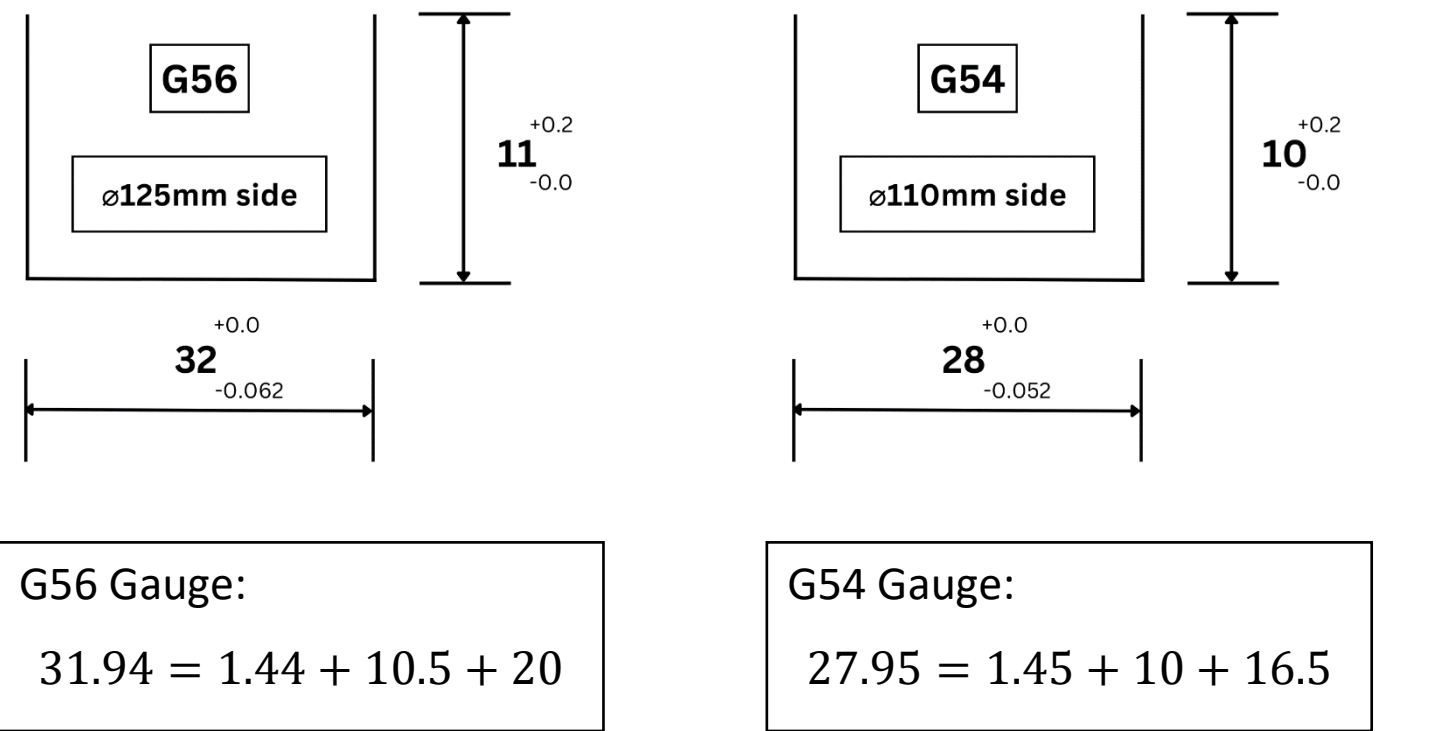
TOLERANCE

Side	125mm - 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	124		170	
Symmetry		0.055		0.055
Reference	18		7.5	

G56: ⌀125mm side – CLOSED SLOT (Left side)

Drawing Reference	18 mm
Centre Distance from reference Collar	44 mm
Centre Distance from reference slot Edge	62 mm

G54: ⌀110mm side – CLOSED SLOT (Right side)
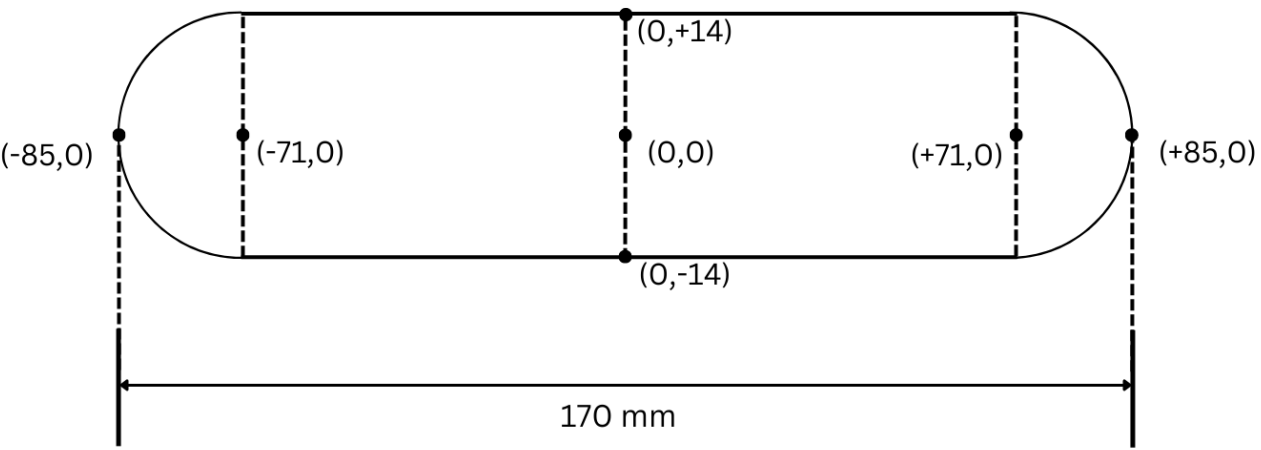
Drawing Reference	7.5 mm
Centre Distance from reference Collar	92.5 mm
Centre Distance from reference slot Edge	85 mm

OFFSETS

NUMBER	TOOL	SIDE	H LOCATION	D LOCATION
13	Marking Pencil	G56	H355	Not Required for Checking
		G54	H356	
14	⌀26.5mm Insert DRILL	G56	H357	Not Required for Drilling
		G54	H358	
15	⌀25mm CUTTER (16mm Insert)	G56	H359	Not Required for Slotting
		G54	H360	
16	⌀25mm CUTTER (9mm Insert)	G56	H361	D361 = 13.0
		G54	H362	D362 = 13.0
17	⌀16mm SC ENDMILL	G56	H363	D363 = 8.4
		G54	H364	D364 = 8.4
		G56	Not required for Finishing	**D365** = 8.2
		G54		**D366** = 8.2

PROGRAMMING

O7341	Checking

* 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).

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.

O7342	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.

O7343		Finishing	
G56	H363	**D365**	R = 8.2
G54	H364	**D366**	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.

O7344	Depth

Depth slotting for middle bar with 16mm Diameter SC End-Mill.

CHECKLIST

O7342		Roughing		
Operation	Side	H Offset	D offset	Radius
Collar cut	G56	H361	**O7349**	
Drilling	G56	H357	Not Required	
	G54	H358		
Slotting	G56	H359		
	G54	H360		
Semi roughing	G56	H361	**O7348**	
	G54	H362	**O7347**	
Semi finishing	G56	H363	D363	R = 8.4
	G54	H364	D364	R = 8.4

O7343		Finishing		
Operation	Side	H Offset	D offset	Radius
Wall finish	G56	H363	**D365**	R = 8.2
	G54	H364	**D366**	R = 8.2

O7344		Depth		
Operation	Side	H Offset	D offset	Radius
Depth finish	G56	H363	Not Required	
	G54	H364		

O7347		Semi Roughing		
Operation	Side	H Offset	D offset	Radius
Sub-program	**G54**		D362	R = 13.0

O7348		Semi Roughing		
Operation	Side	H Offset	D offset	Radius
Sub-program	**G56**		D361	R = 13.0

O7349		Collar Cut		
Operation	Side	H Offset	D offset	Radius
Sub-program	G56		D361	R = 13.0