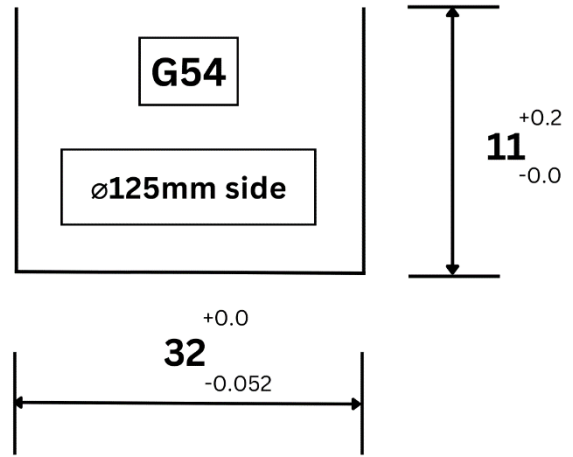
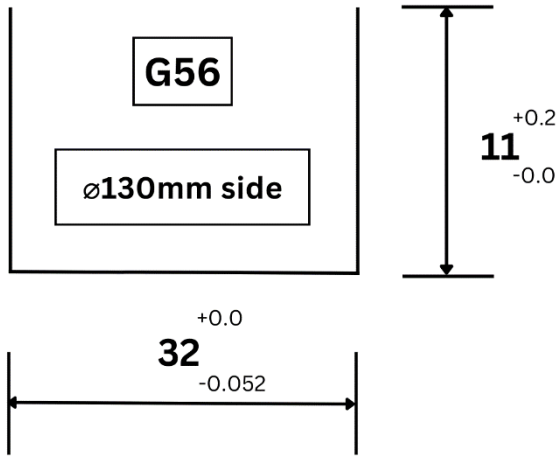


FLENDER DRAWING 5880634

Minimum V-Block Gap for  $\varnothing 130\text{mm}$  diameter = 60 mm



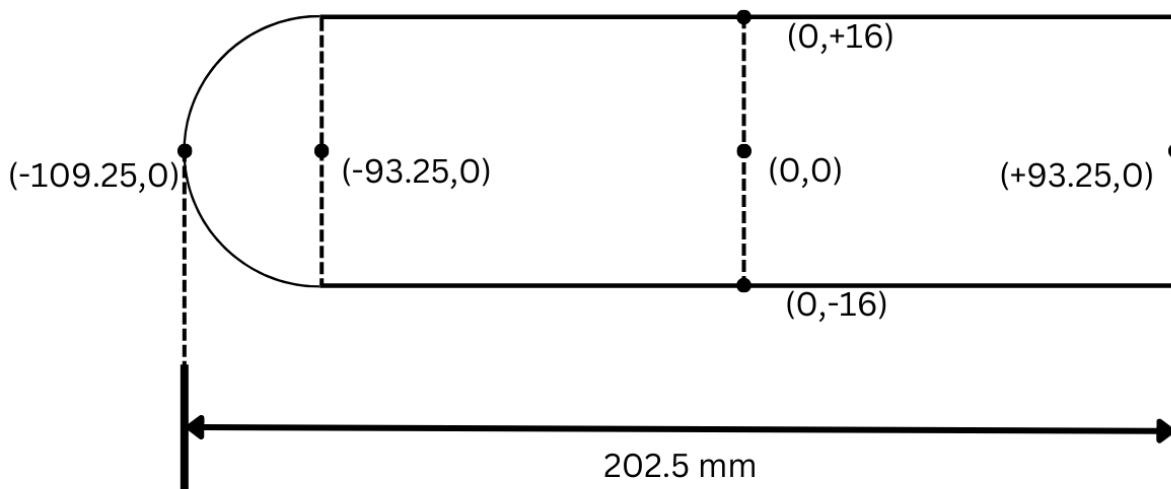
### G56 Gauge:

$$31.94 = 1.44 + 15 + 15.5$$

### G54 Gauge:

$$31.94 = 1.44 + 15 + 15.5$$

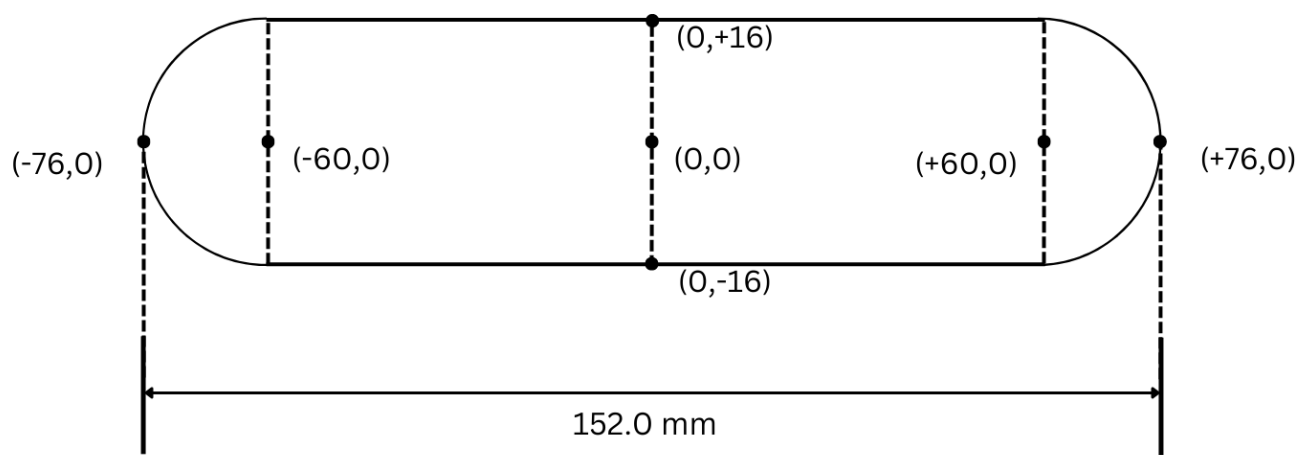
**G54: Ø125mm side – OPEN SLOT (Right side)**



⇒ Drawing Reference = 7.5 mm

⇒ Centre distance from collar = 116.75 mm

G56: Ø130mm side – CLOSED SLOT (Left side)



- ⇒ Drawing Reference = 17 mm
- ⇒ Centre distance from collar = 59 mm

OFFSETS

NUMBER	TOOL	SIDE	H LOCATION	D LOCATION
14	Ø25.6mm Insert DRILL	G56	H230	
		G54	H231	
15	Ø25mm Insert CUTTER	G56	H232	D232 = 13.0
		G54	H233	D233 = 13.0
16	Ø16mm SC CUTTER	G56	H234	D234 = 8.4
		G54	H235	D235 = 8.4
		G56		D236 = 8.15
		G54		D237 = 8.15

# PROGRAMMING

## **O6341** – 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.

## **O6342** – 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.

## **O6343** – 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.

## **O6344** – Depth finishing

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

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