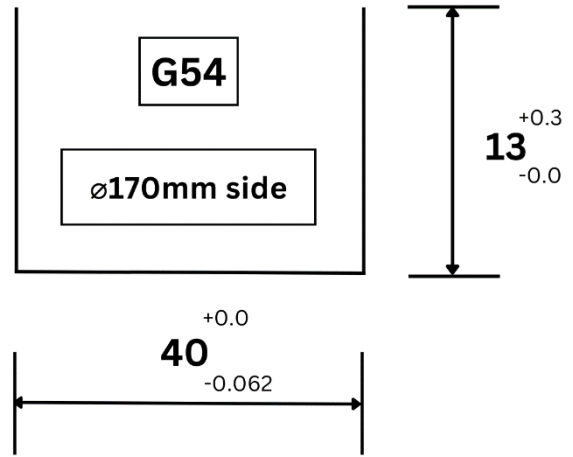
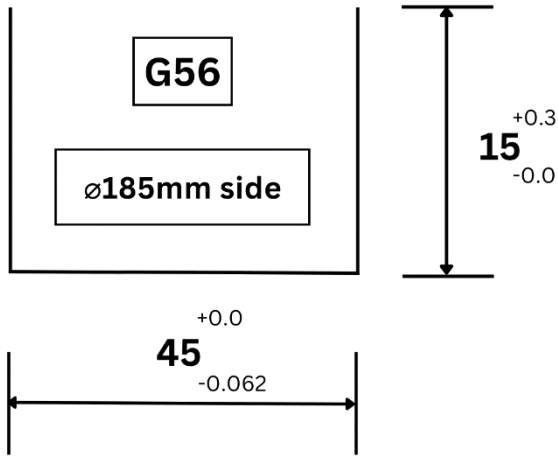


FLENDER DRAWING 5876626

Minimum V-Block Gap for $\varnothing 180\text{mm}$ diameter = 360 mm



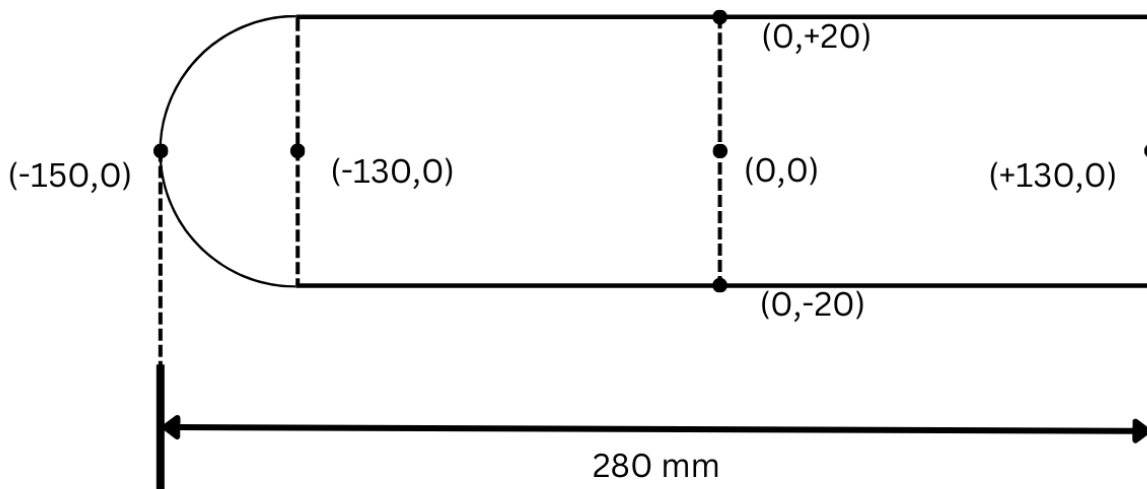
G56 Gauge:

$$44.94 = 1.44 + 20 + 23.5$$

G54 Gauge:

$$39.94 = 1.44 + 18 + 20.5$$

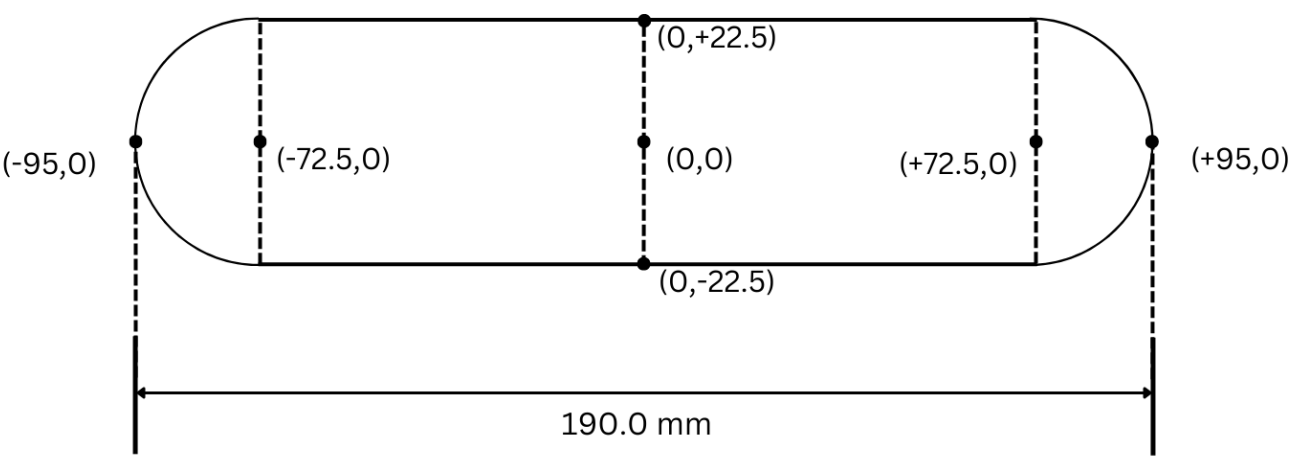
G54: $\varnothing 170\text{mm}$ side – OPEN SLOT (Right side)



⇒ Drawing Reference = 20 mm

⇒ Centre distance from left collar = 170 mm

G56: Ø185mm 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	Ø25mm CUTTER (9mm Insert)	G56	H240	D240 = 13.0
15	Ø26.5mm Insert DRILL	G56	H241	Not Required for Drill
		G54	H242	
16	Ø25mm CUTTER (16mm Insert)	G56	H243	D243 = 13.0
		G54	H244	D244 = 13.0
17	Ø16mm SC ENDMILL	G56	H245	D245 = 8.4
		G54	H246	D246 = 8.4
		G56	Not Required for Finish	D247 = 8.2
		G54		D248 = 8.2

PROGRAMMING

O6261	Checking
<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>	

O6262	Roughing
<p>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.</p>	

O6263		Finishing	
G56	H245	D247	R = 8.2
G54	H246	D248	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	