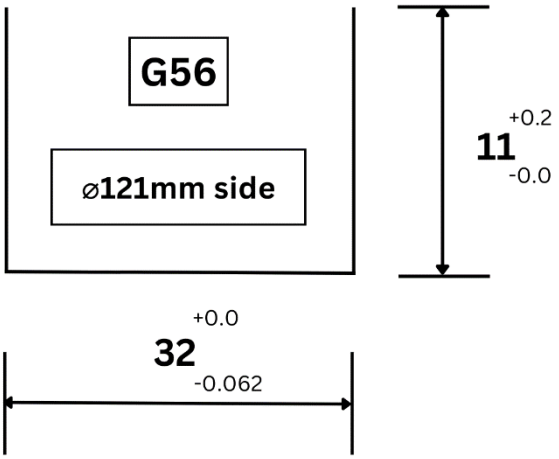
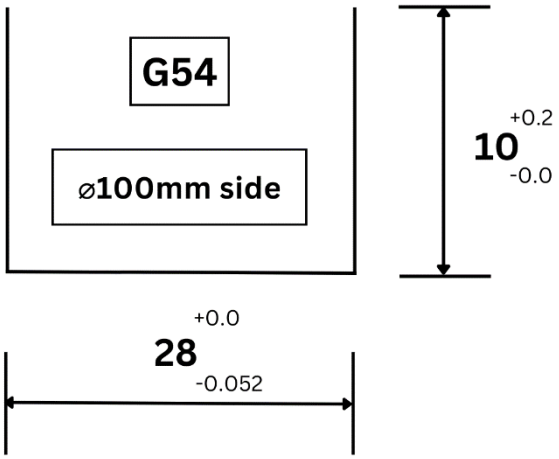
FLENDER DRAWING 5876670

Minimum V-Block Gap for ⌀120mm diameter = 150 mm





G56 Gauge:

$$31.94 = 1.44 + 10.5 + 20$$

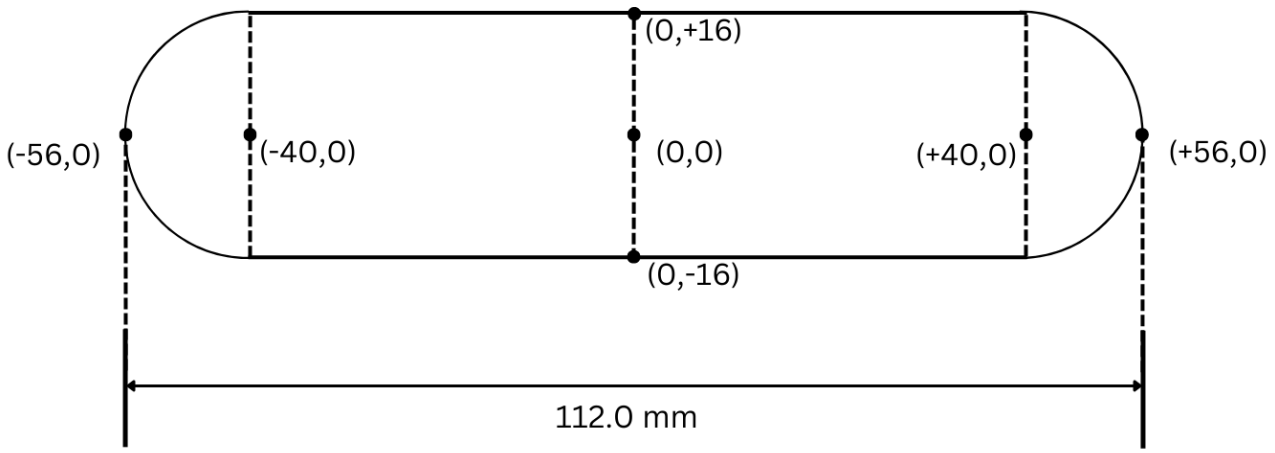
G54 Gauge:

$$27.95 = 1.45 + 10 + 16.5$$

TOLERANCE

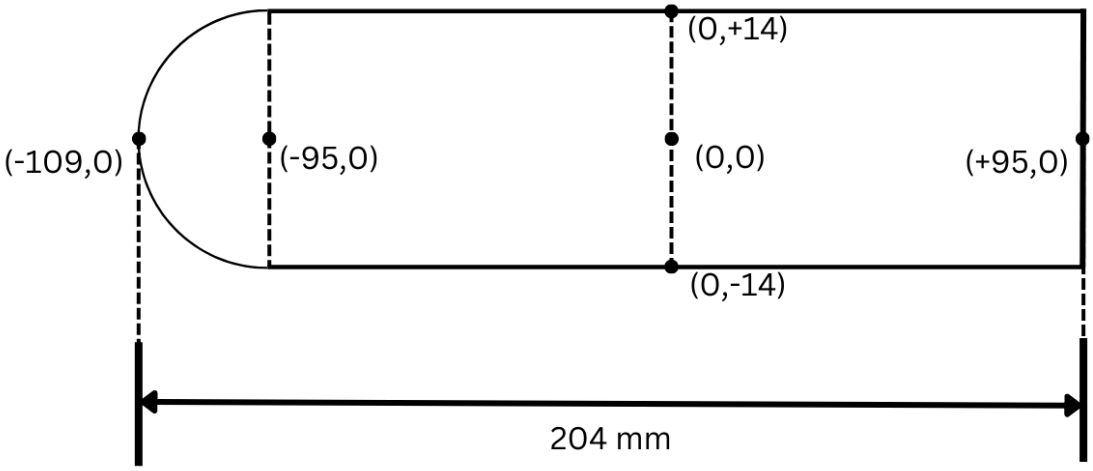
Side	121mm - G56		100mm - G54	
	Actual	Tolerance	Actual	Tolerance
Width	32	+0 / -0.062	28	+0 / -0.052
Depth	11	+0.2 / -0	10	+0.2 / -0
Length	112		204	
Symmetry		0.055		0.066
Reference	17		6	

G56: ⌀121mm side – CLOSED SLOT (Left side)



Drawing Reference	17 mm
Centre Distance from reference Collar	39 mm
Centre Distance from reference slot Edge	56 mm

G54: ⌀100mm side – OPEN SLOT (Right side)



Drawing Reference	6 mm
Centre Distance from reference Collar	115 mm
Centre Distance from reference slot Edge	109 mm

OFFSETS

NUMBER	TOOL	SIDE	H LOCATION	D LOCATION
13	Marking Pencil	G56	H310	Not Required for Checking
		G54	H311	
14	⌀26.5mm Insert DRILL	G56	H312	Not Required for Drilling
		G54	H313	
15	⌀25mm CUTTER (16mm Insert)	G56	H314	Not Required for Slotting
		G54	H315	
16	⌀25mm CUTTER (9mm Insert)	G56	H316	D316 = 13.0
		G54	H317	D317 = 13.0
17	⌀16mm SC ENDMILL	G56	H318	D318 = 8.4
		G54	H319	D319 = 8.4
		G56	Not Required for Finishing	**D320** = 8.2
		G54		**D321** = 8.2

PROGRAMMING

O6701	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.	

O6702	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.	

O6703		Finishing	
G56	H318	**D320**	R = 8.2
G54	H319	**D321**	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.			

O6704	Depth
Depth slotting for middle bar with 16mm Diameter SC End-Mill.	

CHECKLIST

O6702		Roughing		
Operation	Side	H Offset	D offset	Radius
Collar cut	G56	H316	**O6709**	
Drilling	G56	H312	Not Required	
	G54	H313		
Slotting	G56	H314		
	G54	H315		
Semi roughing	G56	H316	**O6708**	
	G54	H317	**O6707**	
Semi finishing	G56	H318	D318	R = 8.4
	G54	H319	D319	R = 8.4

O6703		Finishing		
Operation	Side	H Offset	D offset	Radius
Wall finish	G56	H318	**D320**	R = 8.2
	G54	H319	**D321**	R = 8.2

O6704		Depth		
Operation	Side	H Offset	D offset	Radius
Depth finish	G56	H318	Not Required	
	G54	H319		

O6707		Semi Roughing		
Operation	Side	H Offset	D offset	Radius
Sub-program	**G54**		D317	R = 13.0

O6708		Semi Roughing		
Operation	Side	H Offset	D offset	Radius
Sub-program	**G56**		D316	R = 13.0

O6709		Collar Cut		
Operation	Side	H Offset	D offset	Radius
Sub-program	G56		D316	R = 13.0