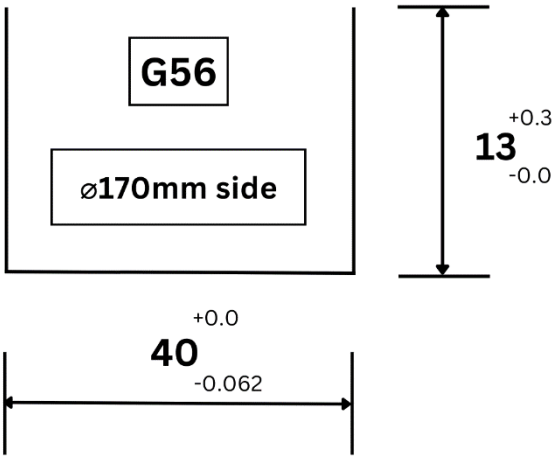
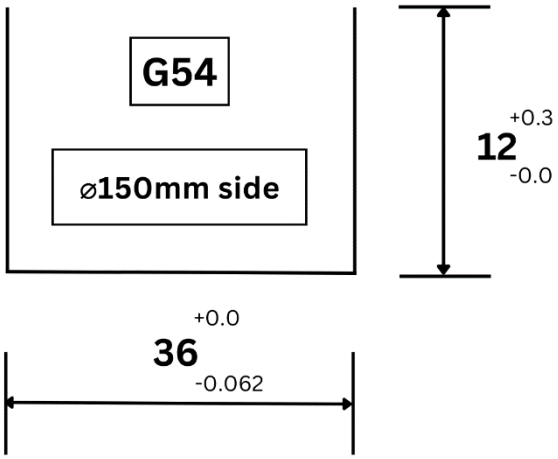
FLENDER DRAWING **F2E00738926A**

Minimum V-Block Gap for ⌀160mm diameter = 190 mm





G56 Gauge:

$$39.94 = 1.44 + 18 + 20.5$$

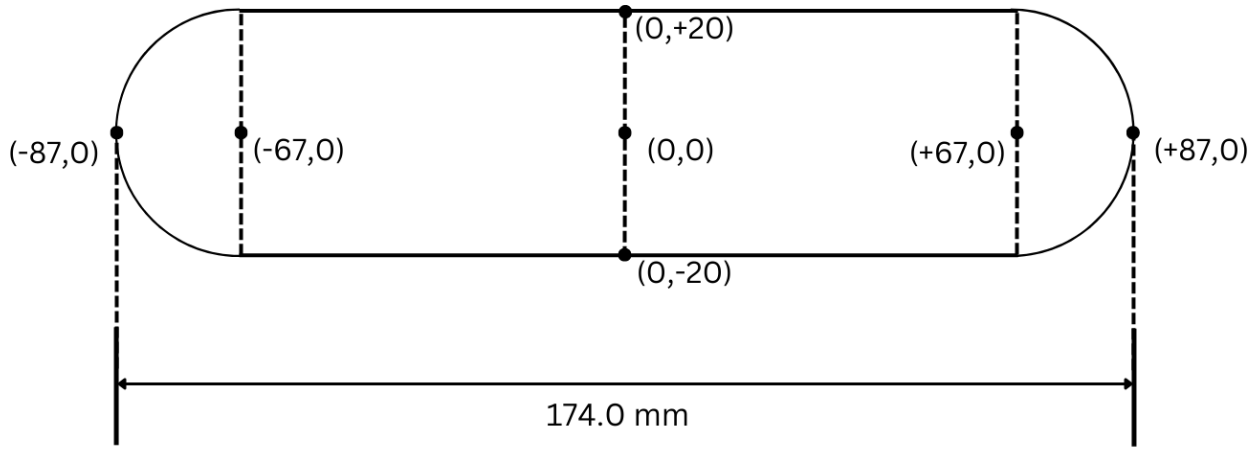
G54 Gauge:

$$35.94 = 1.44 + 14.5 + 20$$

TOLERANCE

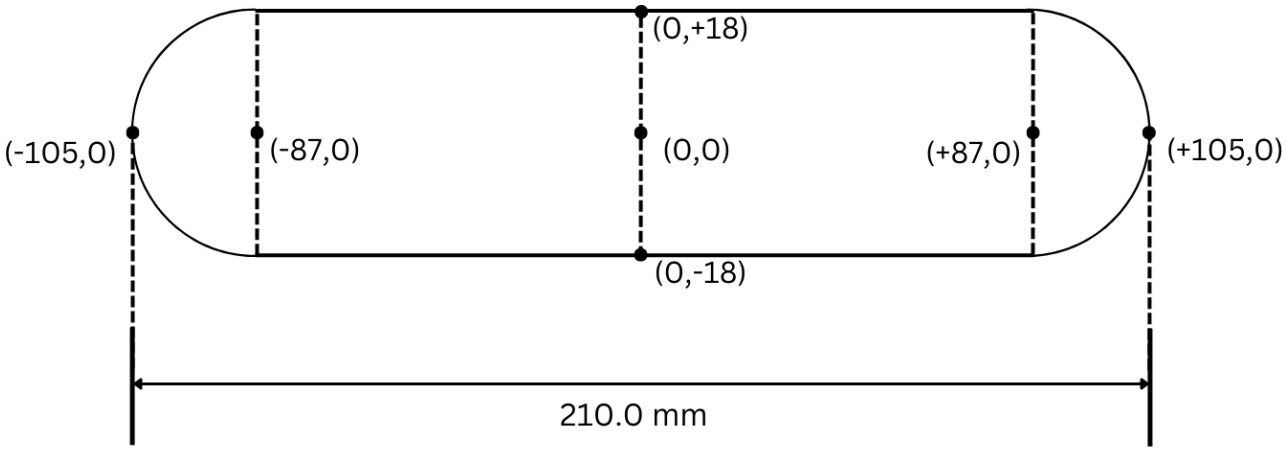
Side	170mm - G56		150mm - G54	
	Actual	Tolerance	Actual	Tolerance
Width	40	+0 / -0.062	36	+0 / -0.062
Depth	13	+0.3 / -0	12	+0.3 / -0
Length	174		210	
Symmetry		0.070		0.055
Reference	23.5		16	

G56: ⌀170mm side – CLOSED SLOT (Left side)



Drawing Reference	23.5 mm
Centre Distance from reference Collar	63.5 mm
Centre Distance from reference slot Edge	87 mm

G54: ⌀150mm side – CLOSED SLOT (Right side)



Drawing Reference	16 mm
Centre Distance from reference Collar	121 mm
Centre Distance from reference slot Edge	105 mm

OFFSETS

NUMBER	TOOL	SIDE	H LOCATION	D LOCATION
13	Marking Pencil	G56	H60	Not Required for Checking
		G54	H61	
14	⌀26.5mm Insert DRILL	G56	H62	Not Required for Drilling
		G54	H63	
15	⌀25mm CUTTER (16mm Insert)	G56	H64	Not Required for Slotting
		G54	H65	
16	⌀25mm CUTTER (9mm Insert)	G56	H66	D66 = 13.0
		G54	H67	D67 = 13.0
17	⌀16mm SC ENDMILL	G56	H68	D68 = 8.4
		G54	H69	D69 = 8.4
		G56	Not Required for Finishing	**D70** = 8.2
		G54		**D71** = 8.2

PROGRAMMING

O8261	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.	

O8262	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.	

O8263		Finishing	
G56	H68	**D70**	R = 8.2
G54	H69	**D71**	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.			

O8264	Depth
Depth slotting for middle bar with 16mm Diameter SC End-Mill.	

CHECKLIST

O8262		Roughing		
Operation	Side	H Offset	D offset	Radius
Collar cut	G56	H66	**O8269**	
Drilling	G56	H62	Not Required for Drilling	
	G54	H63		
Slotting	G56	H64	Not Required for Slotting	
	G54	H65		
Semi roughing	G56	H66	**O8268**	
	G54	H67	**O8267**	
Semi finishing	G56	H68	D68	R = 8.4
	G54	H69	D69	R = 8.4

O8263		Finishing		
Operation	Side	H Offset	D offset	Radius
Wall finish	G56	H68	**D70**	R = 8.2
	G54	H69	**D71**	R = 8.2

O8264		Depth		
Operation	Side	H Offset	D offset	Radius
Depth finish	G56	H68	Not Required for Depth cut	
	G54	H69		

O8267		Semi Roughing		
Operation	Side	H Offset	D offset	Radius
Sub-program	**G54**		D67	R = 13.0

O8268		Semi Roughing		
Operation	Side	H Offset	D offset	Radius
Sub-program	**G56**		D66	R = 13.0

O8269		Collar Cut		
Operation	Side	H Offset	D offset	Radius
Sub-program	G56		D66	R = 13.0